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Moon et al.

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(54) **SEMICONDUCTOR PACKAGE**

USPC 438/255, 398, 665, 964; 257/309
See application file for complete search history.

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 14 days.

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Primary Examiner — Calvin Lee

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H01L 21/44	(2006.01)
H01L 23/498	(2006.01)
H01L 23/48	(2006.01)
H01L 23/31	(2006.01)

(57) **ABSTRACT**

A semiconductor package includes a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface, and a first encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip. A metal layer is disposed on the first encapsulant, and includes a first conductive layer and a second conductive layer, sequentially stacked. A connection structure is disposed on the active surface of the semiconductor chip, and includes a first redistribution layer electrically connected to the connection pad. A lower surface of the first conductive layer is in contact with the first encapsulant and has first surface roughness, and an upper surface of the first conductive layer is in contact with the second conductive layer and has second surface roughness smaller than the first surface roughness.

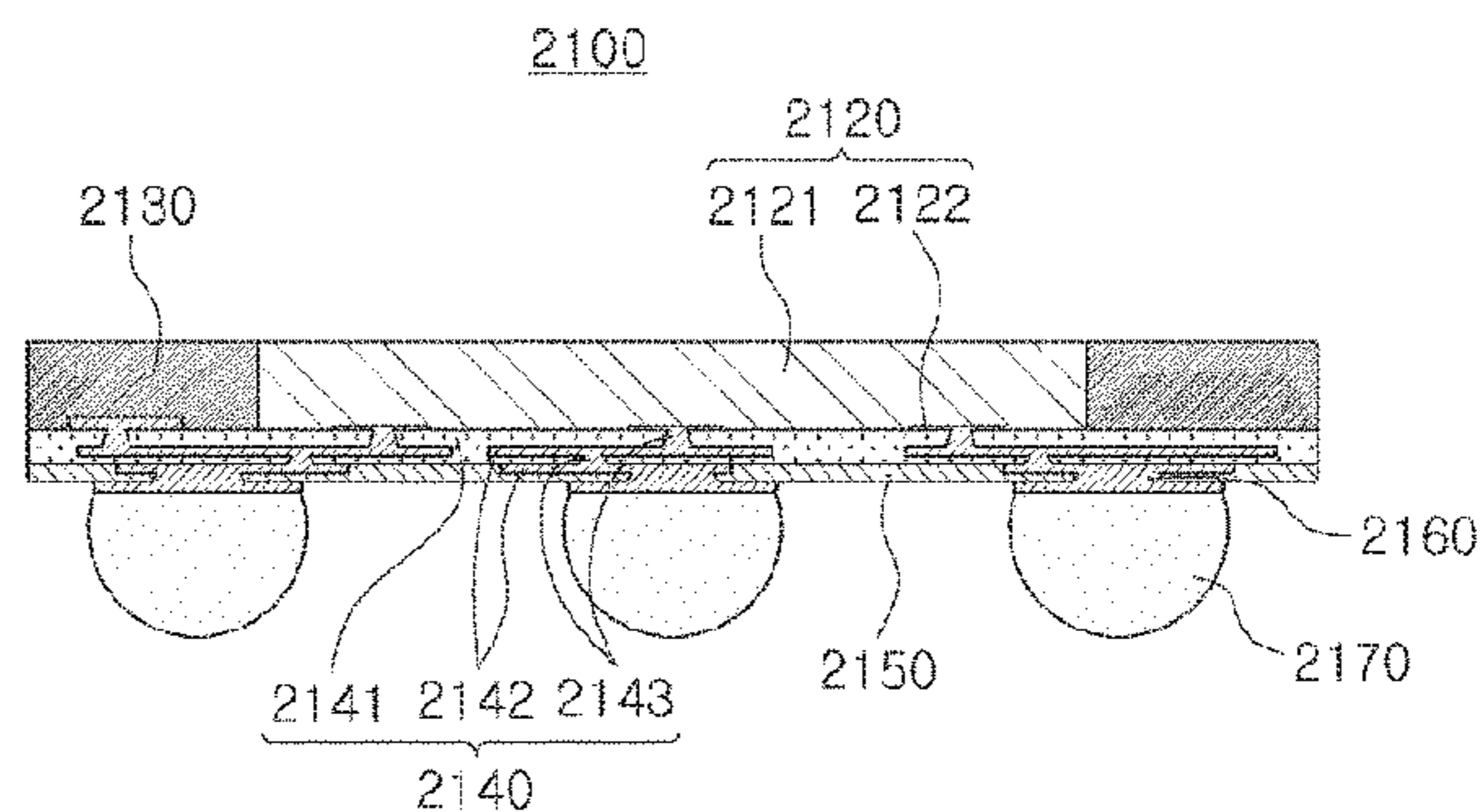
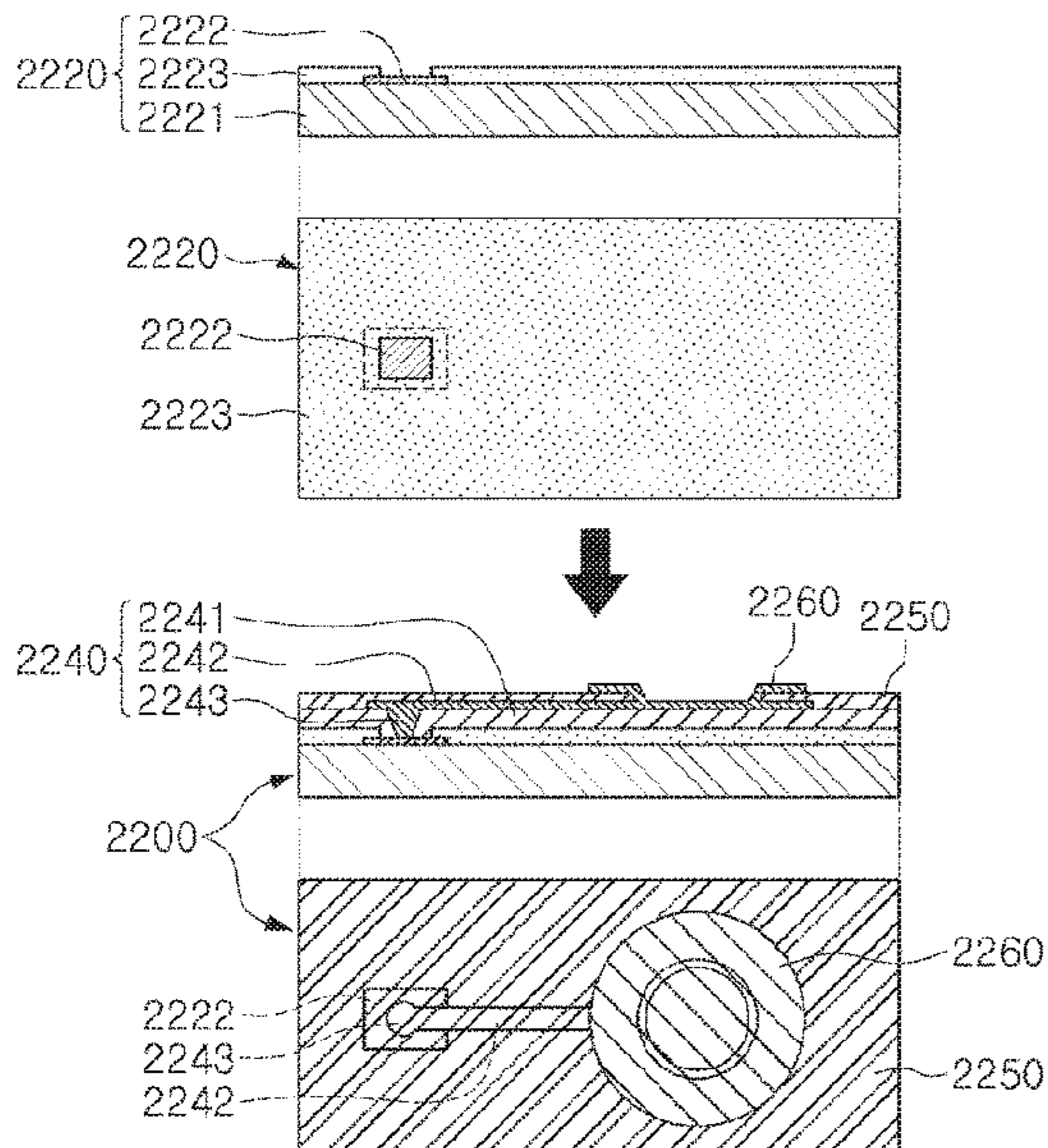
(52) **U.S. Cl.**

CPC **H01L 23/49861** (2013.01); **H01L 23/3114** (2013.01); **H01L 23/481** (2013.01); **H01L 2224/0233** (2013.01)

20 Claims, 20 Drawing Sheets

(58) **Field of Classification Search**

CPC H01L 23/49891; H01L 21/67336; H01L 21/67343



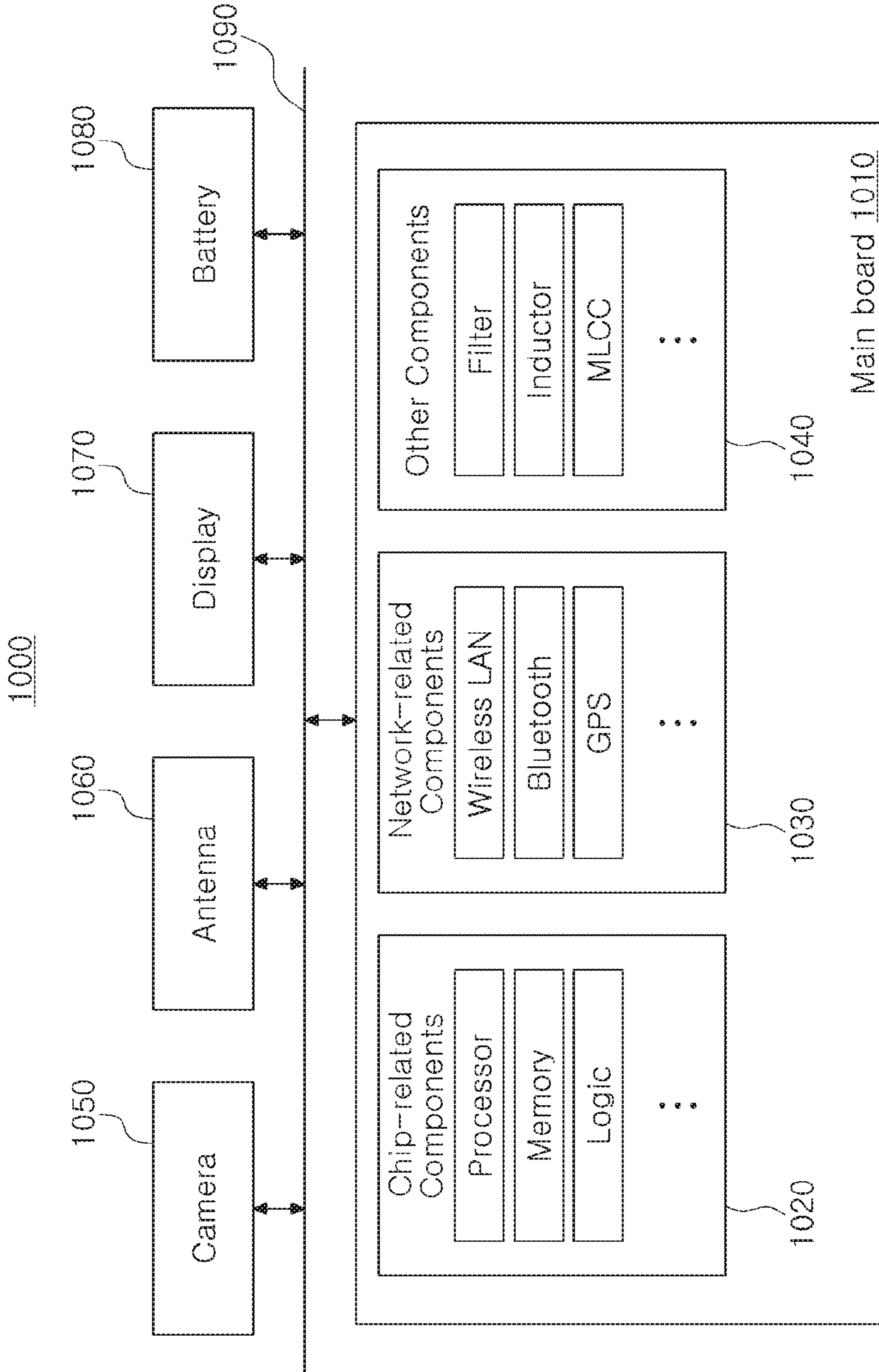


FIG. 1

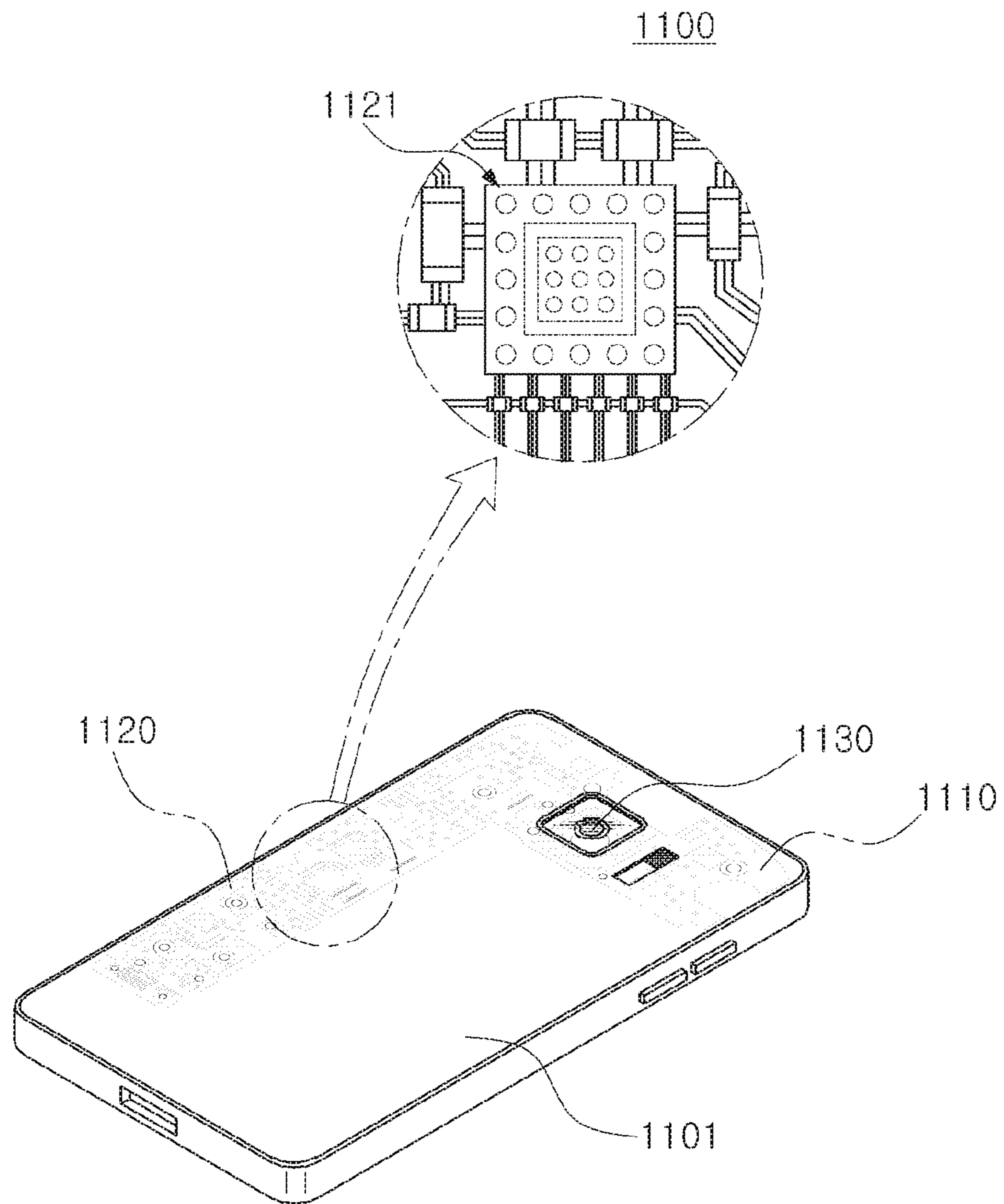


FIG. 2

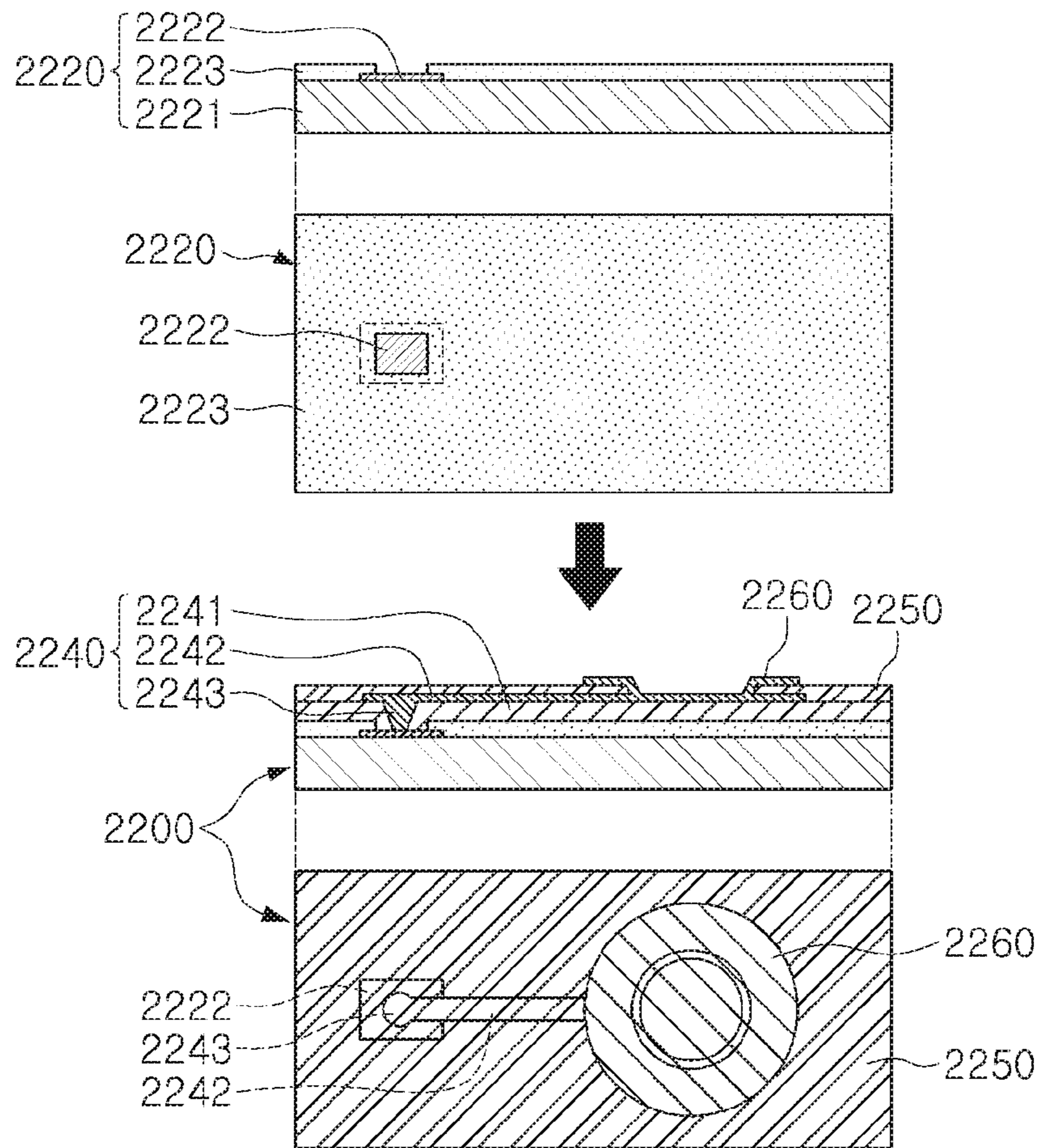


FIG. 3A

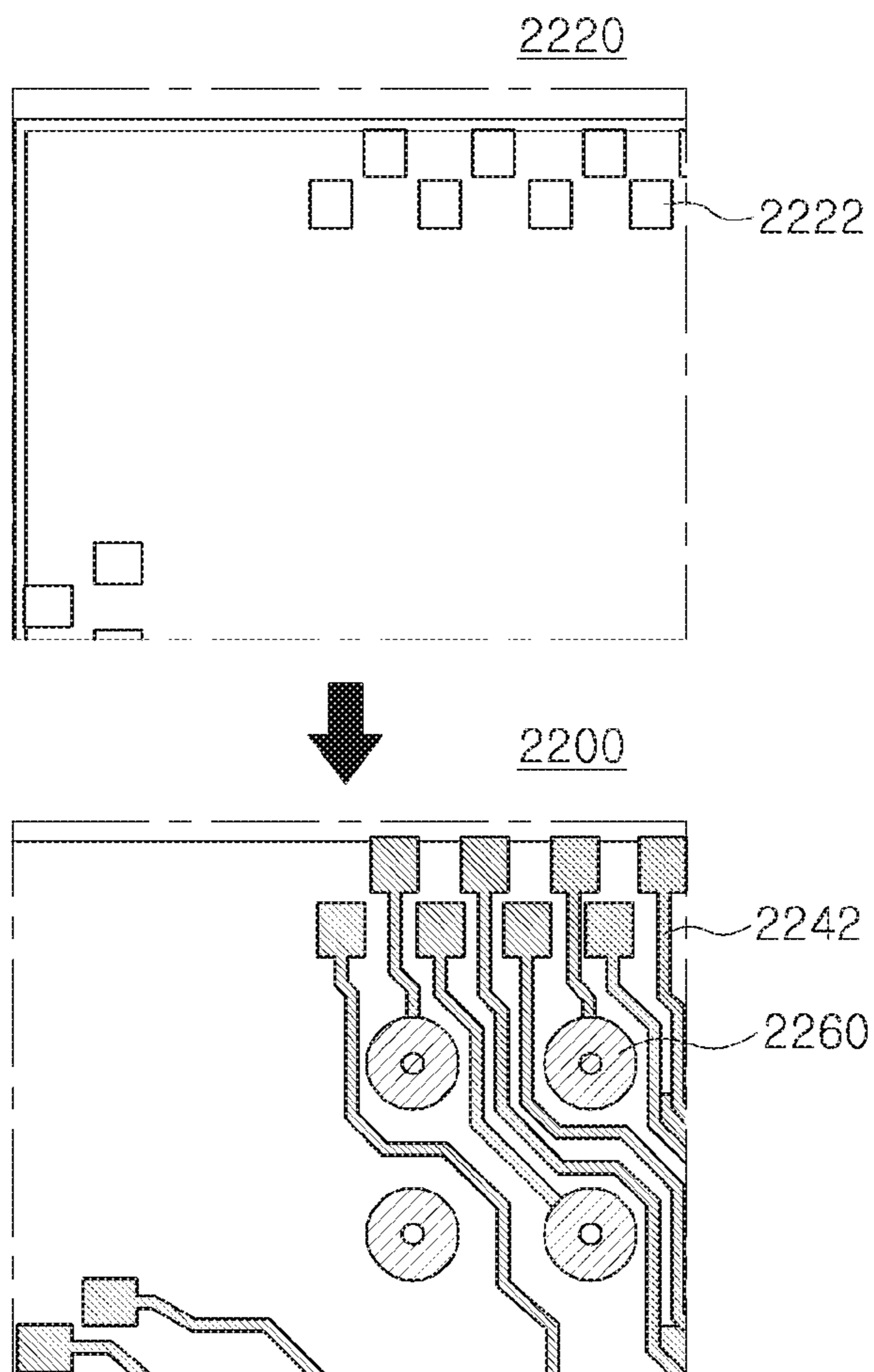


FIG. 3B

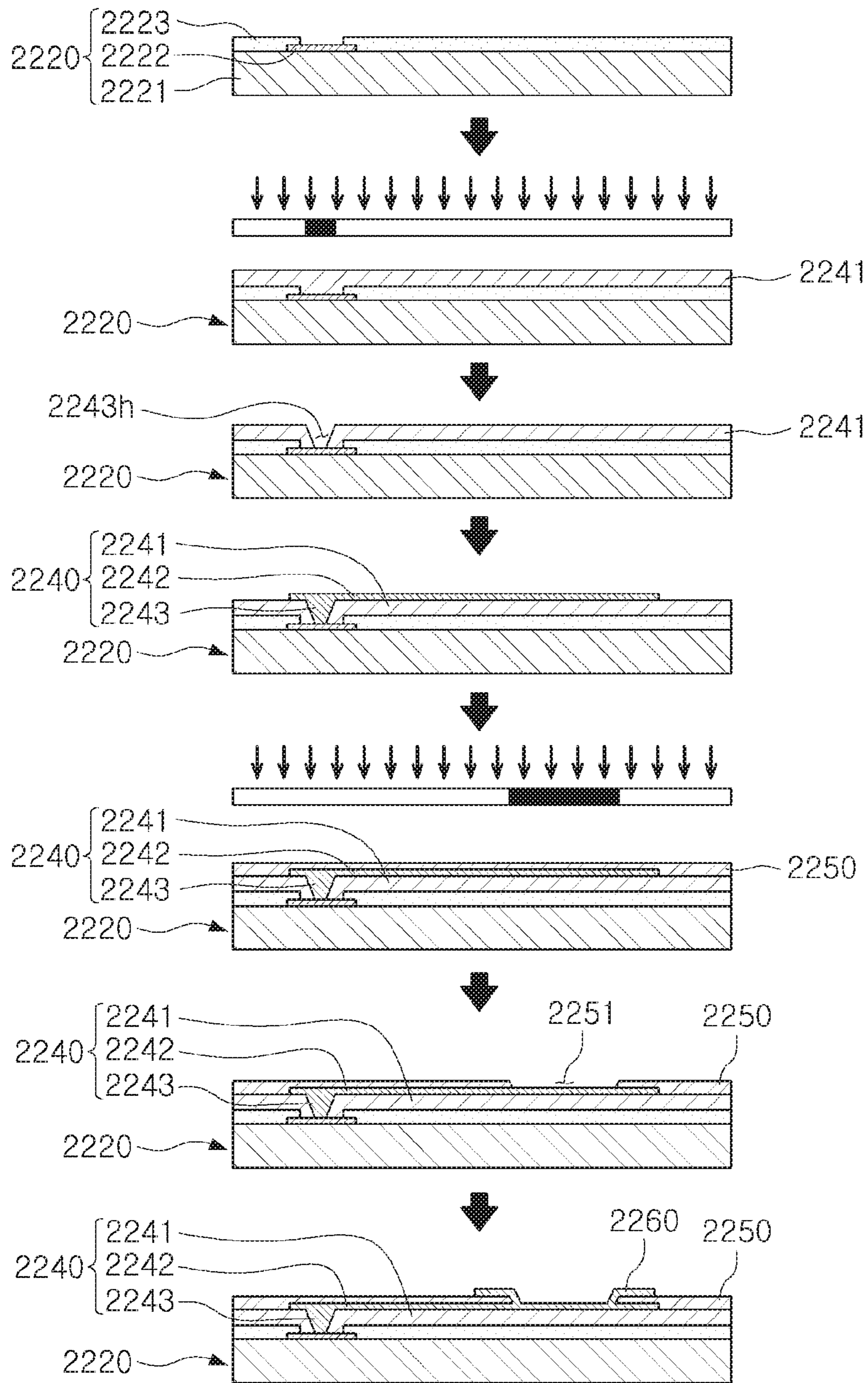


FIG. 4

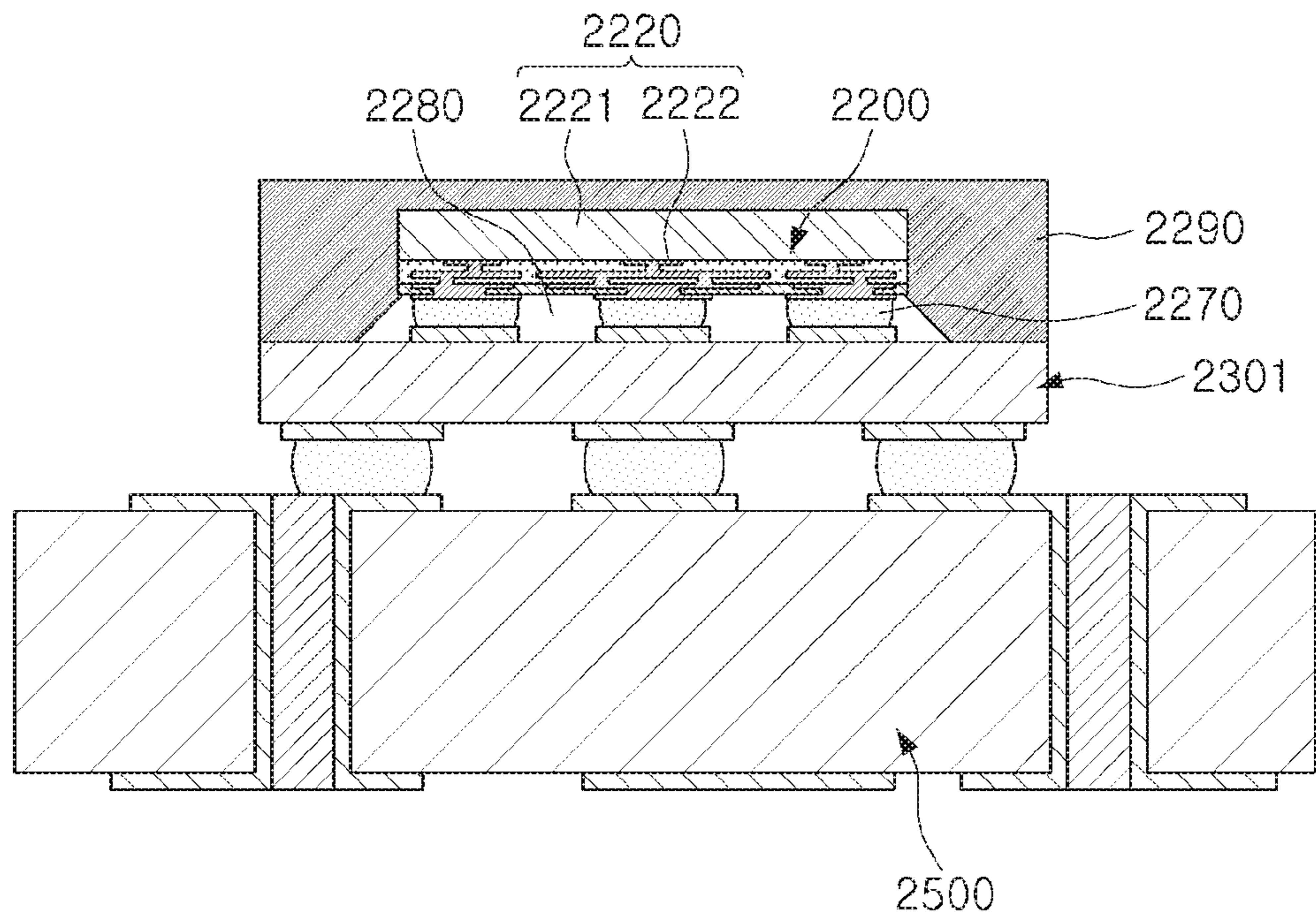


FIG. 5

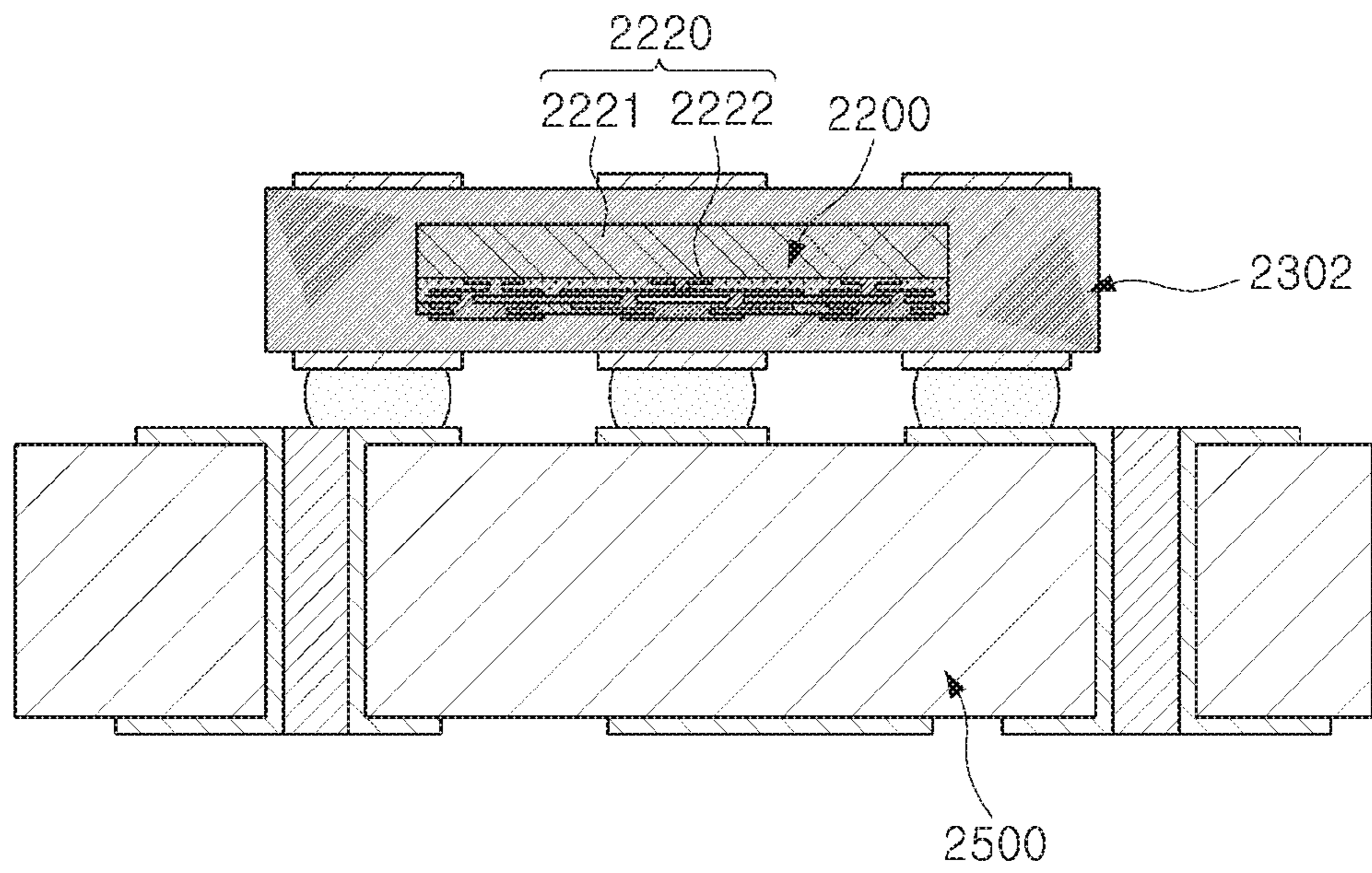


FIG. 6

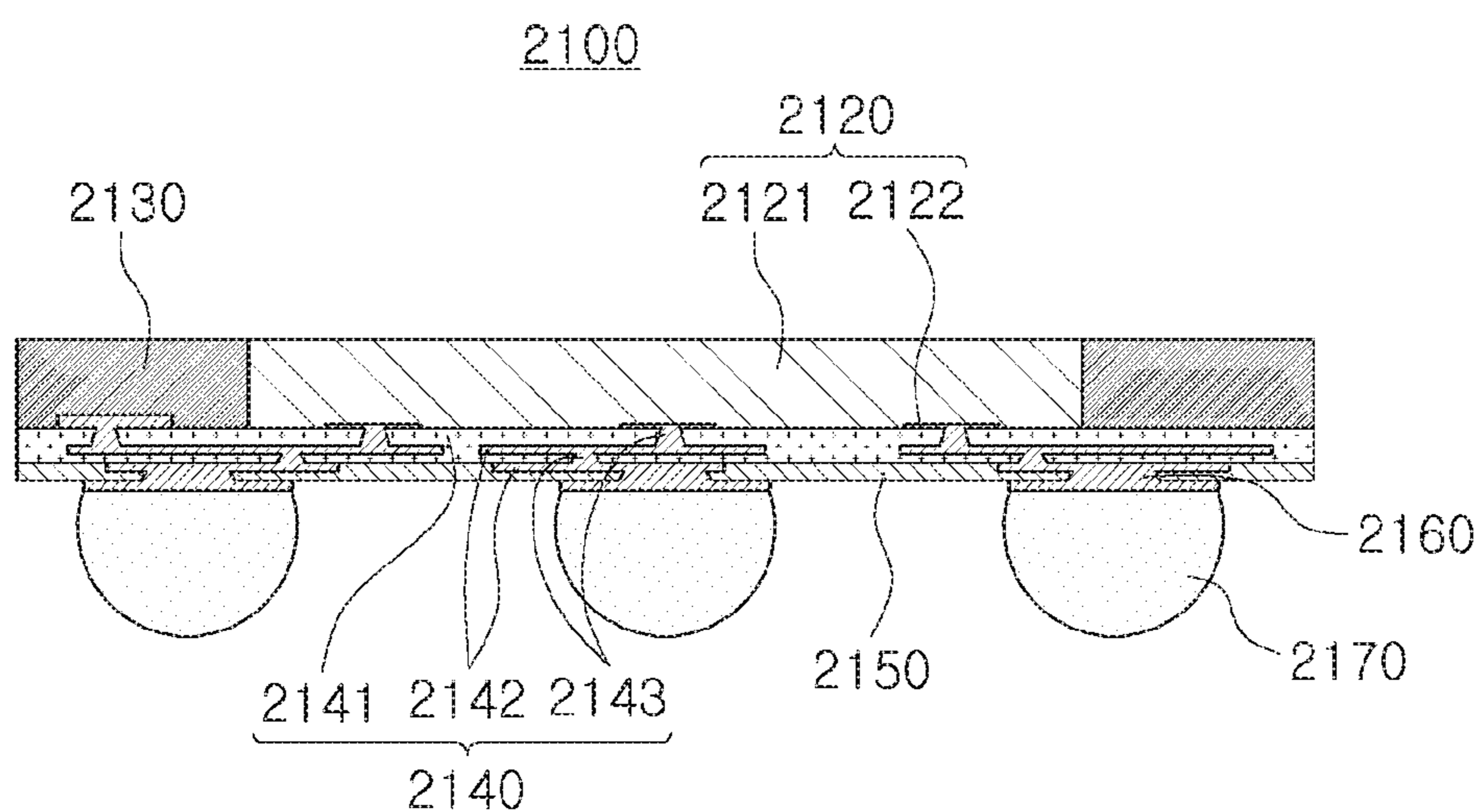


FIG. 7

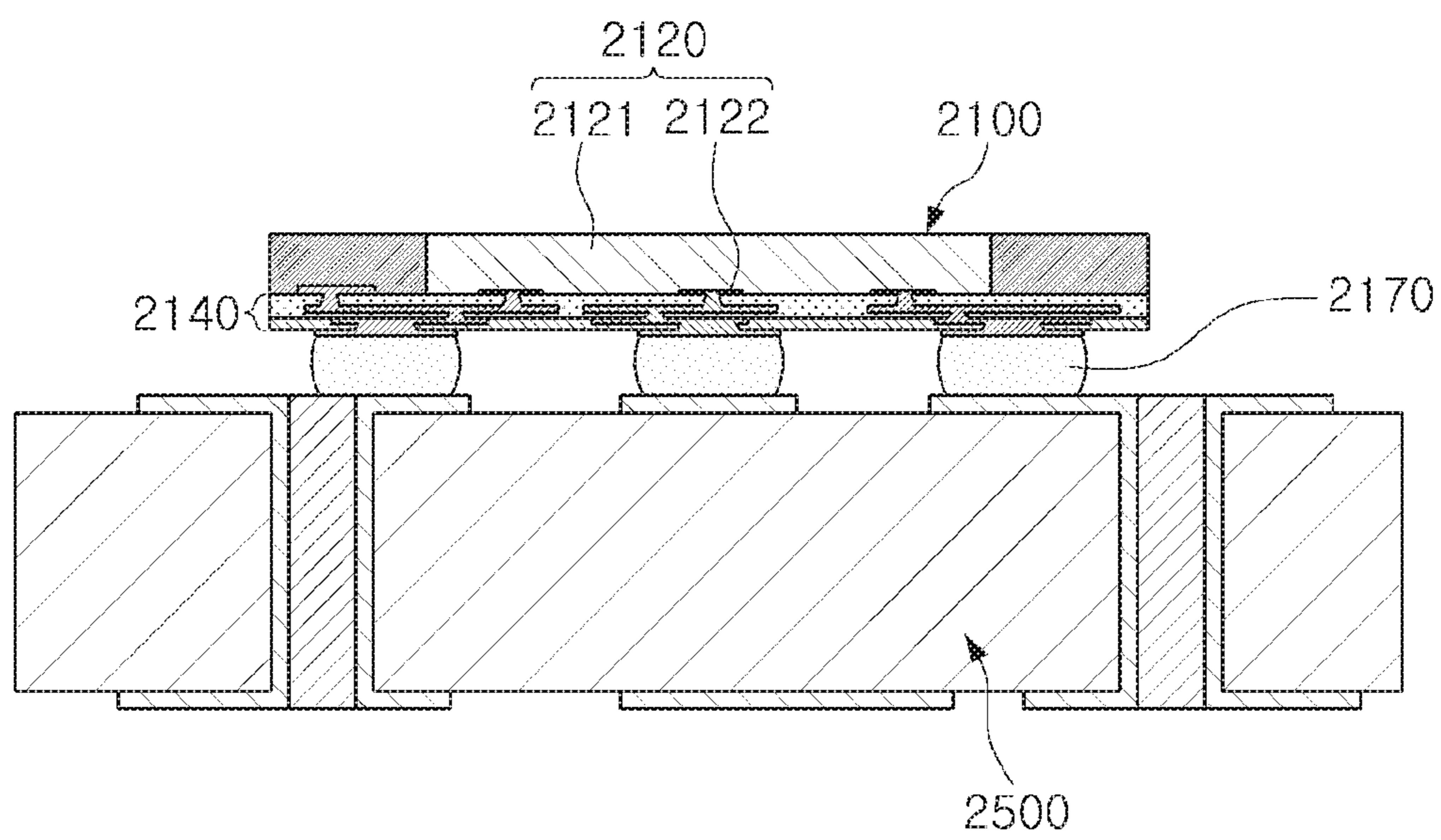


FIG. 8

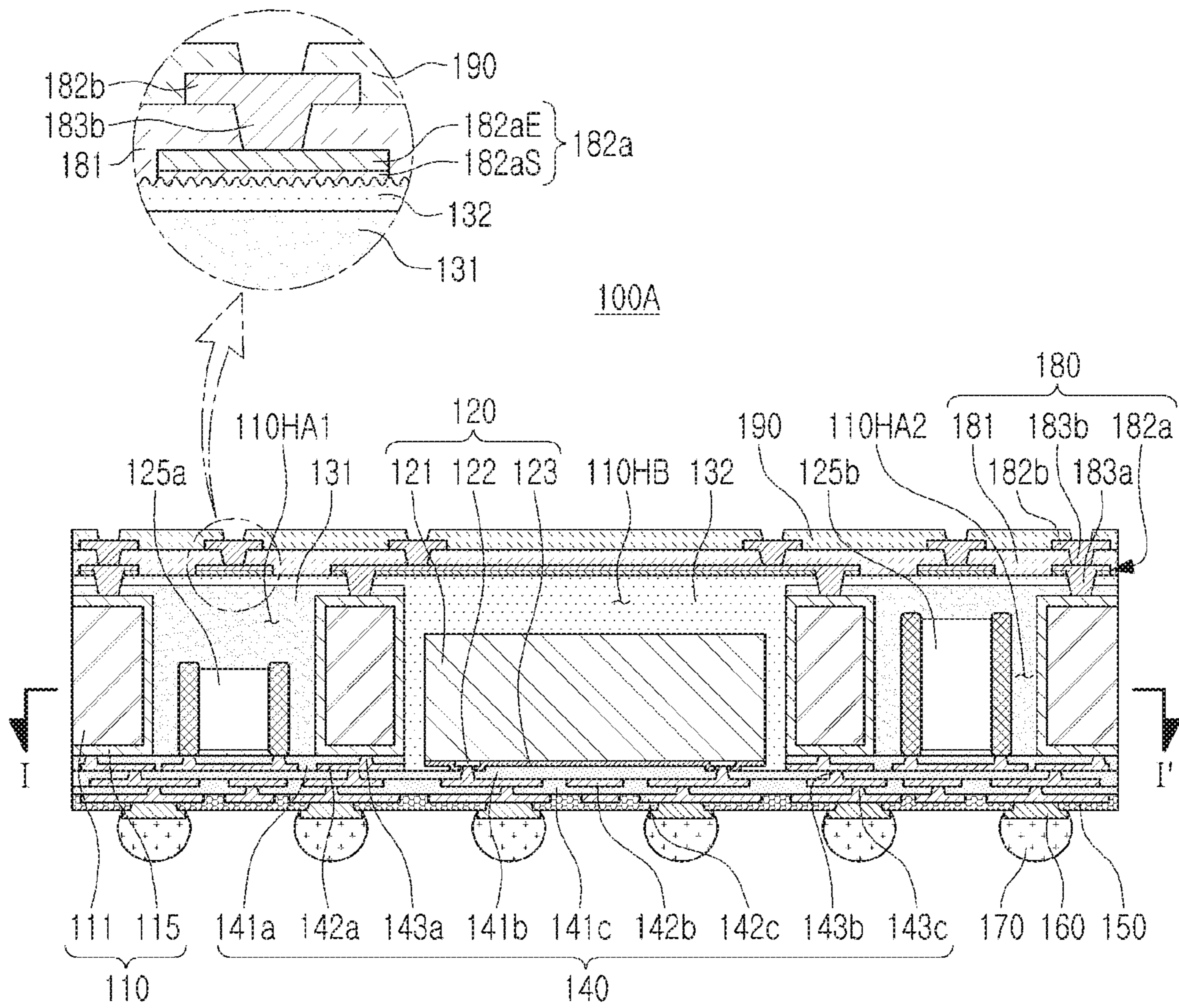
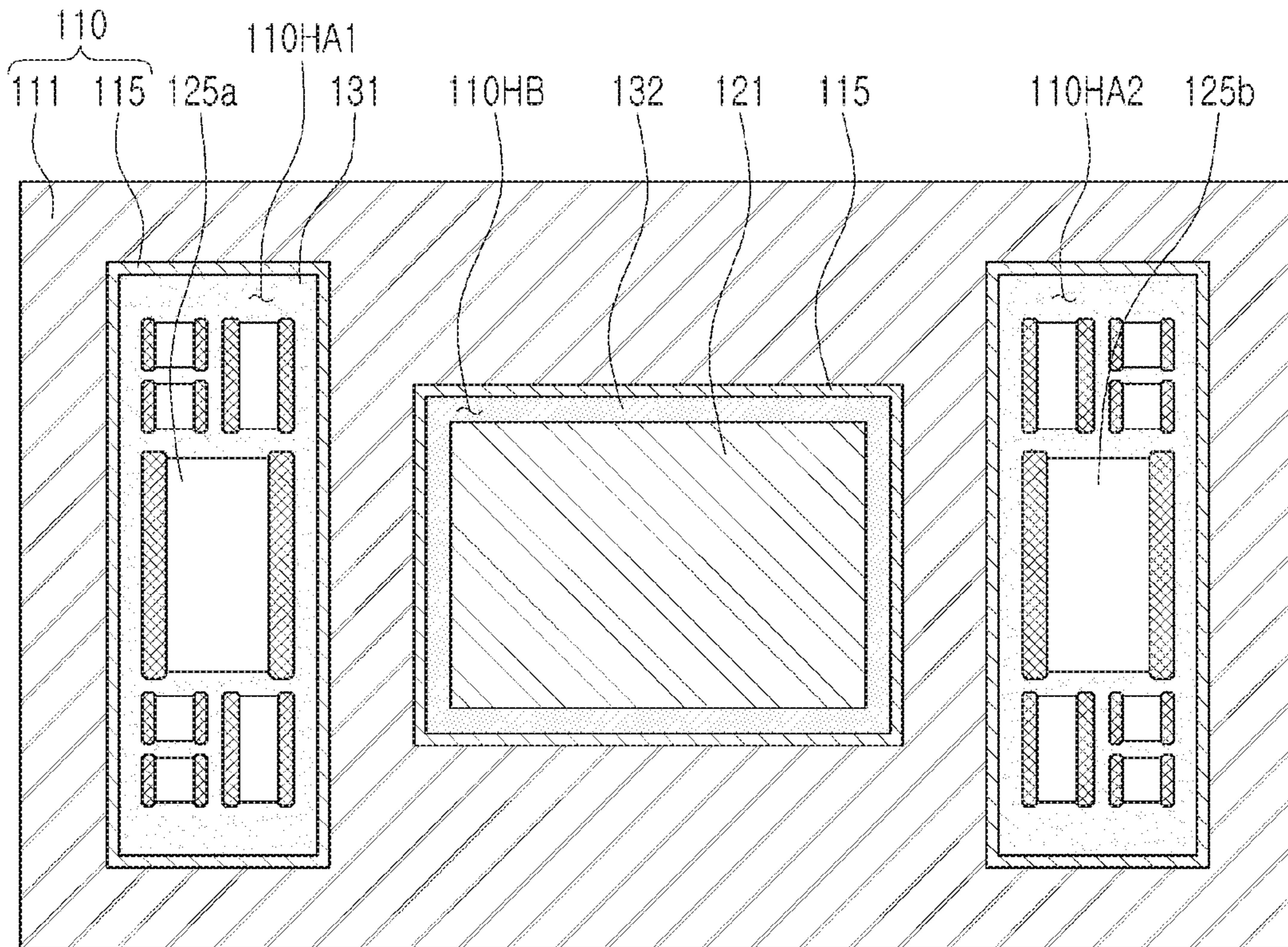


FIG. 9



I-I'

FIG. 10

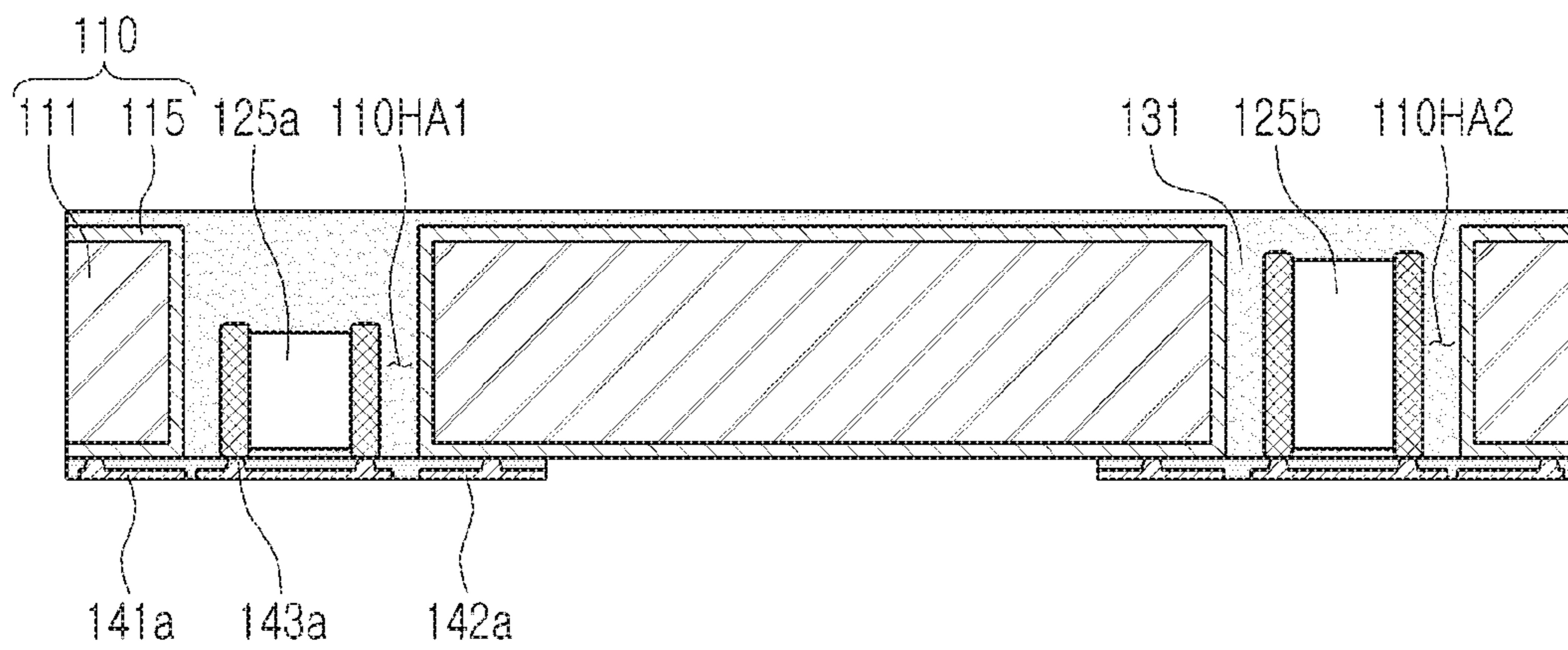
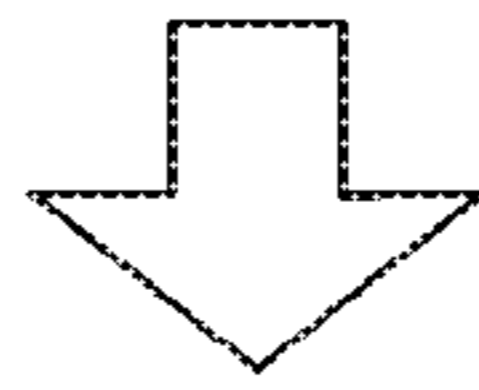
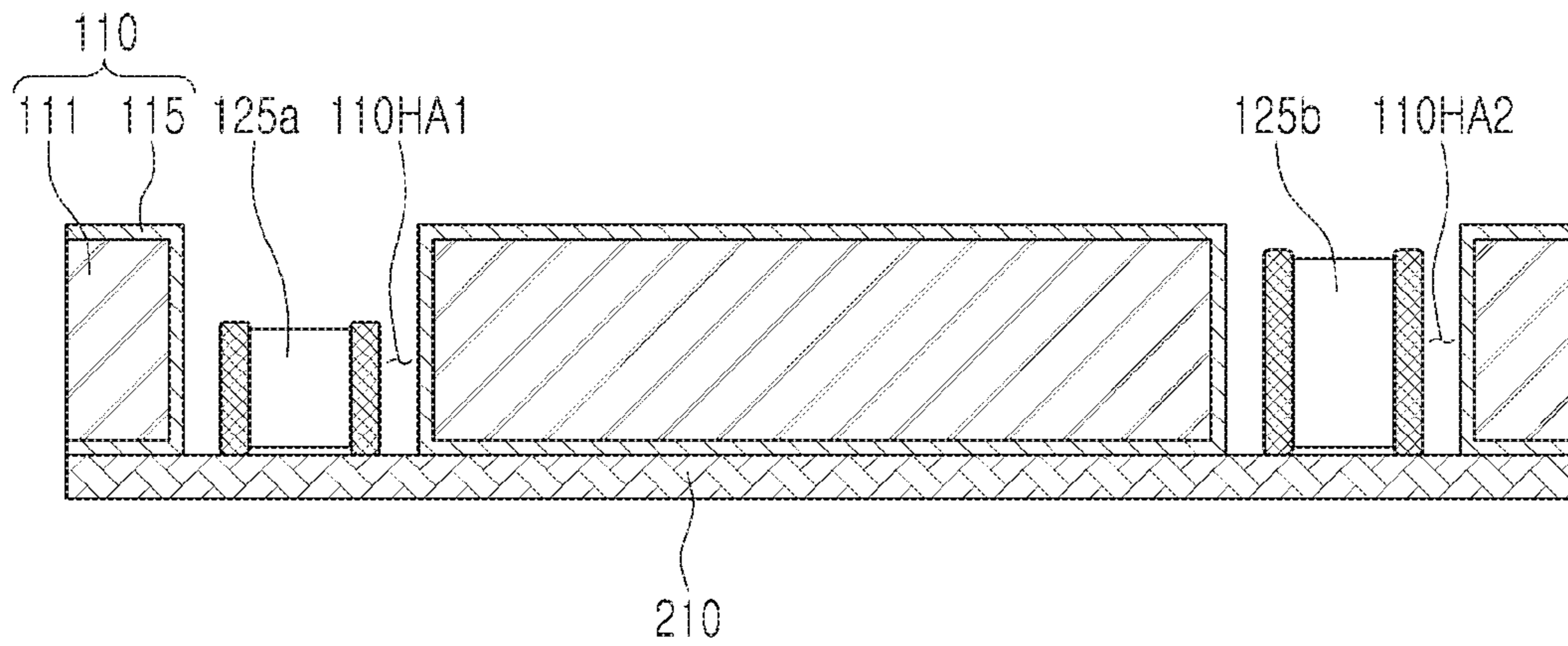


FIG. 11A

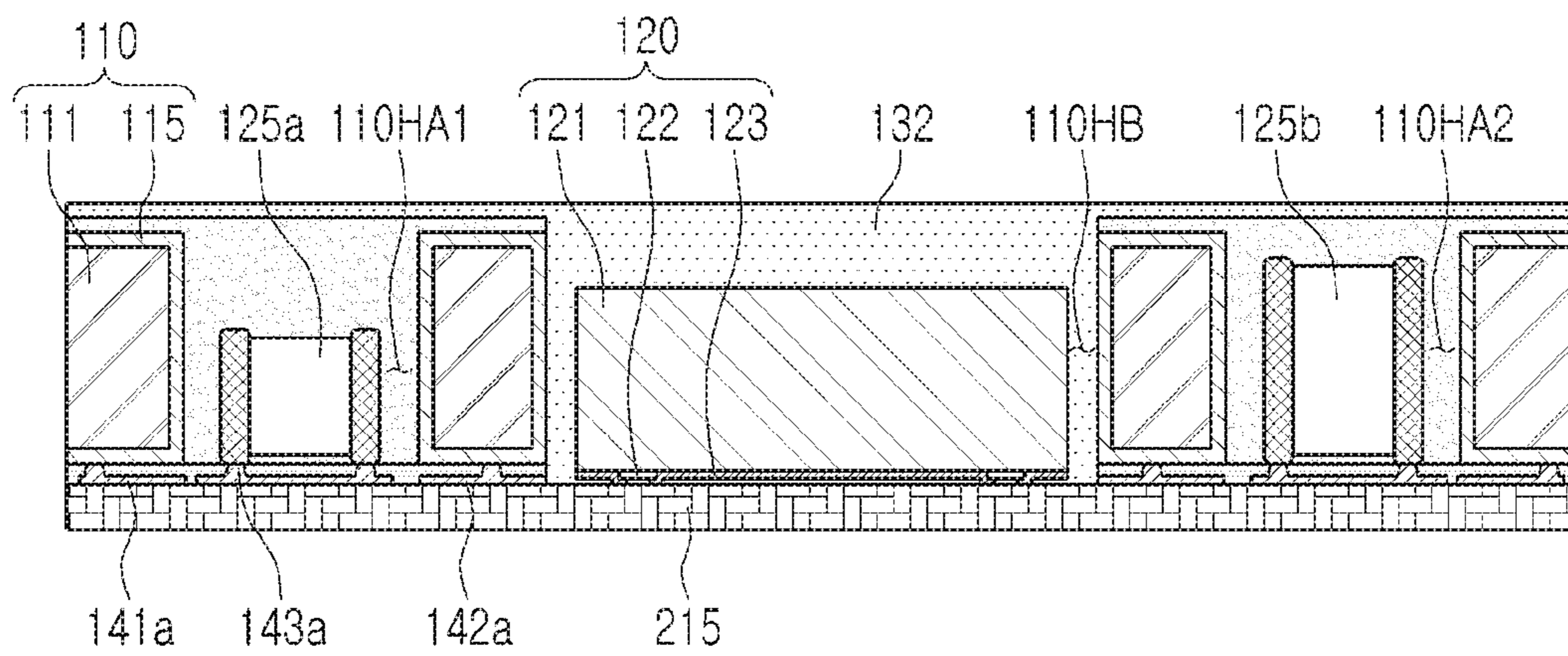
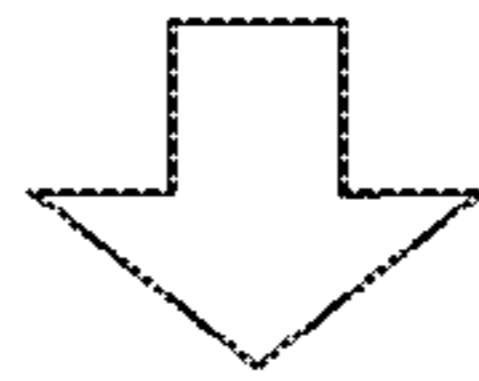
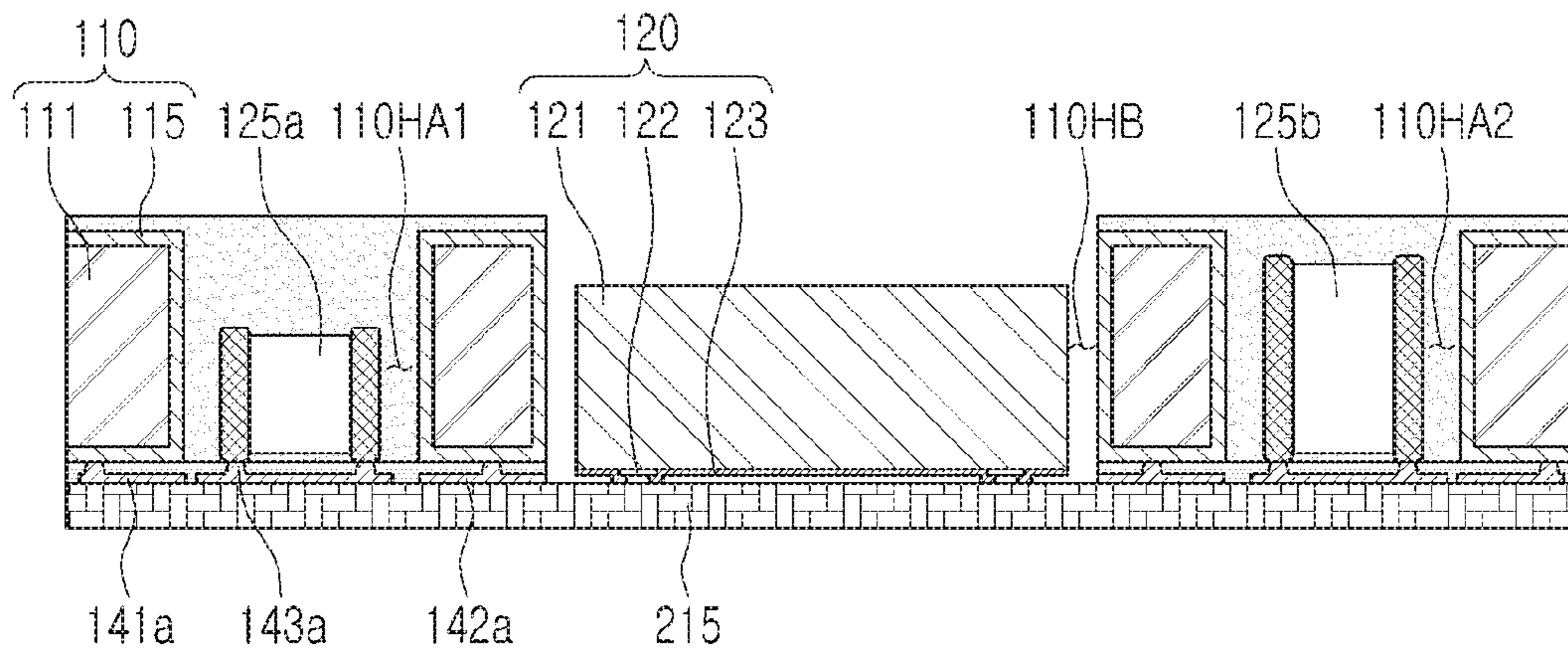


FIG. 11B

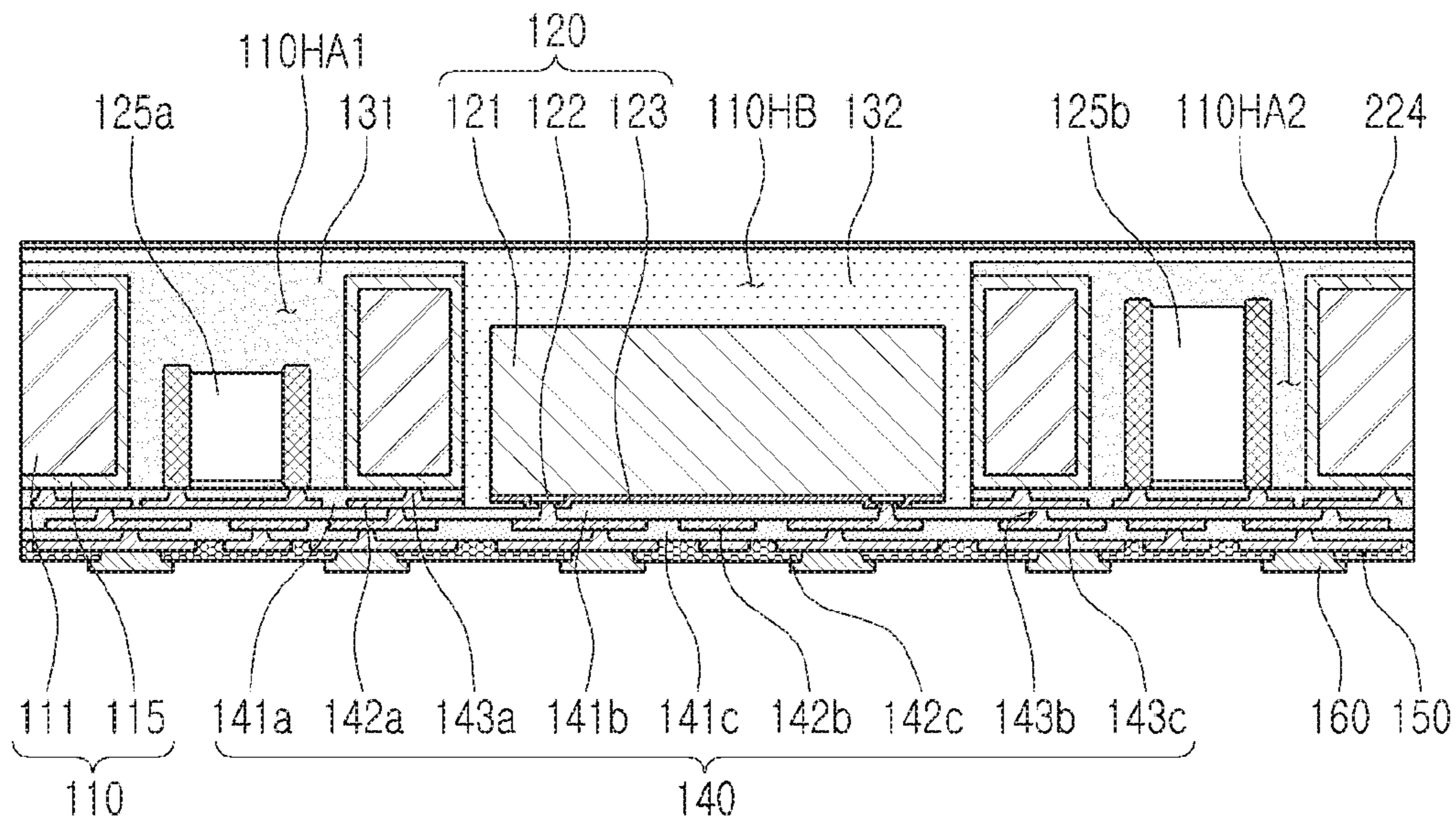
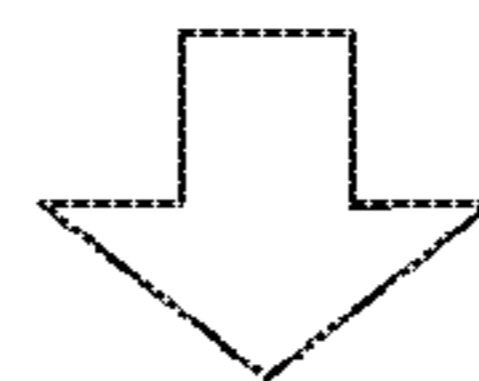
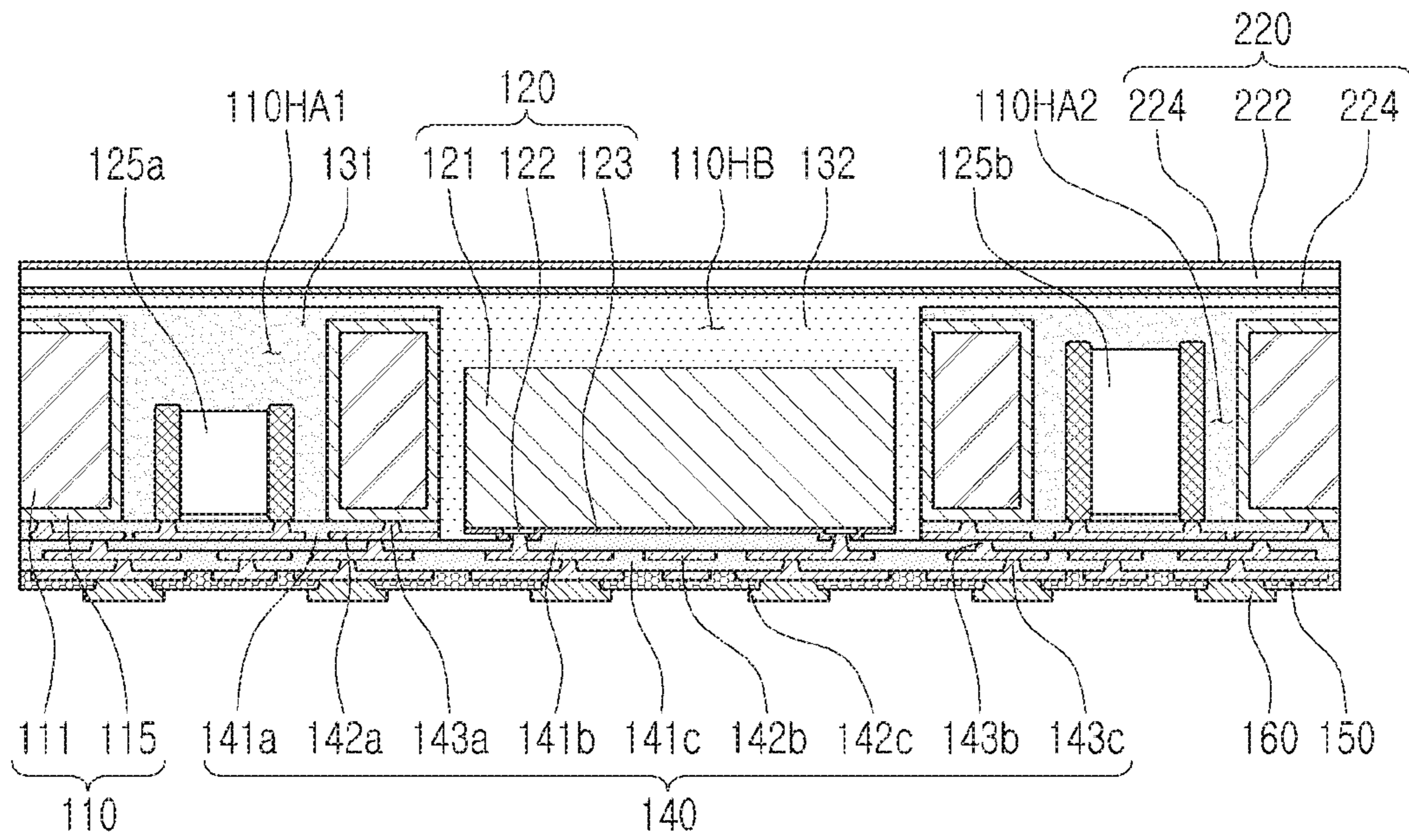


FIG. 11C

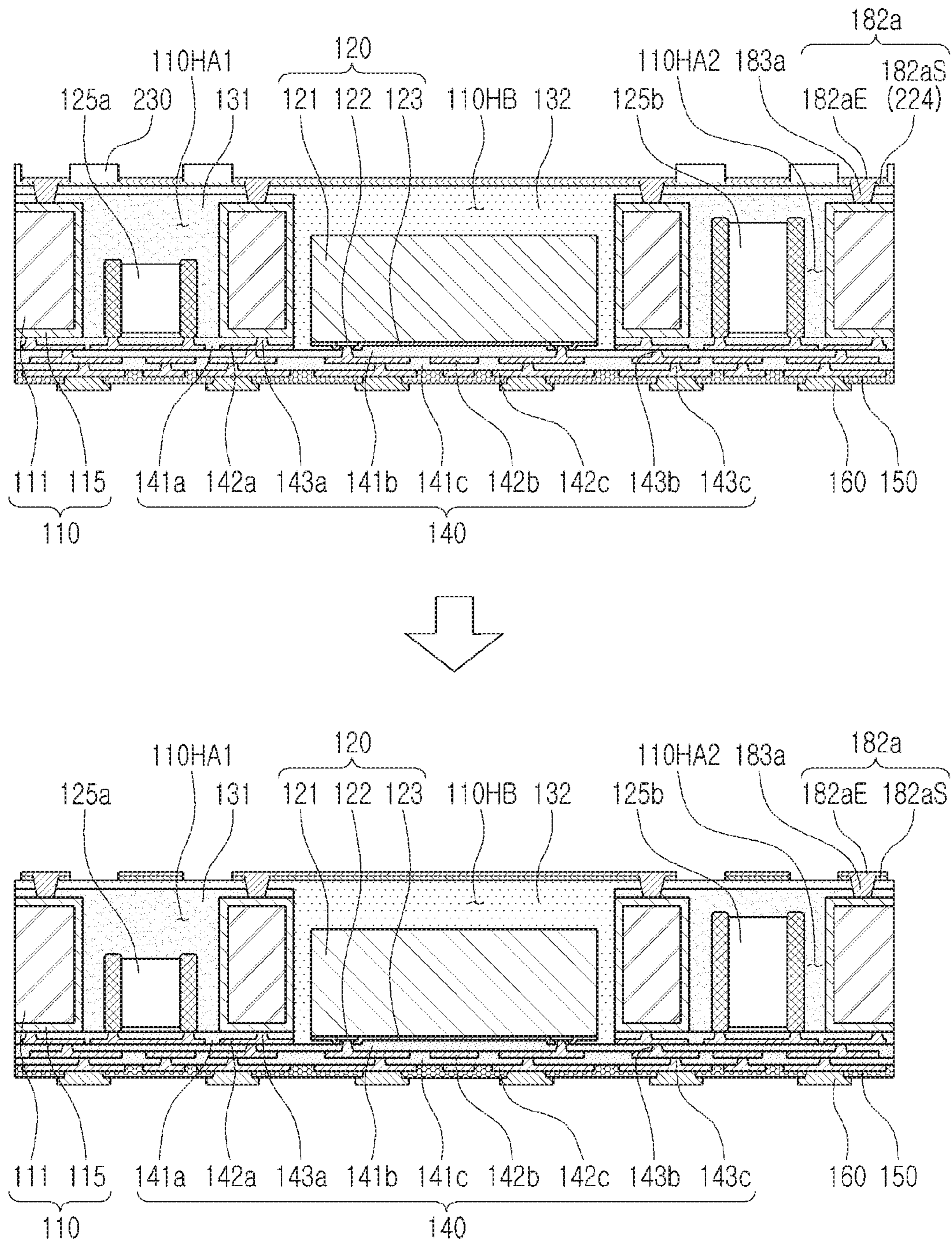


FIG. 11D

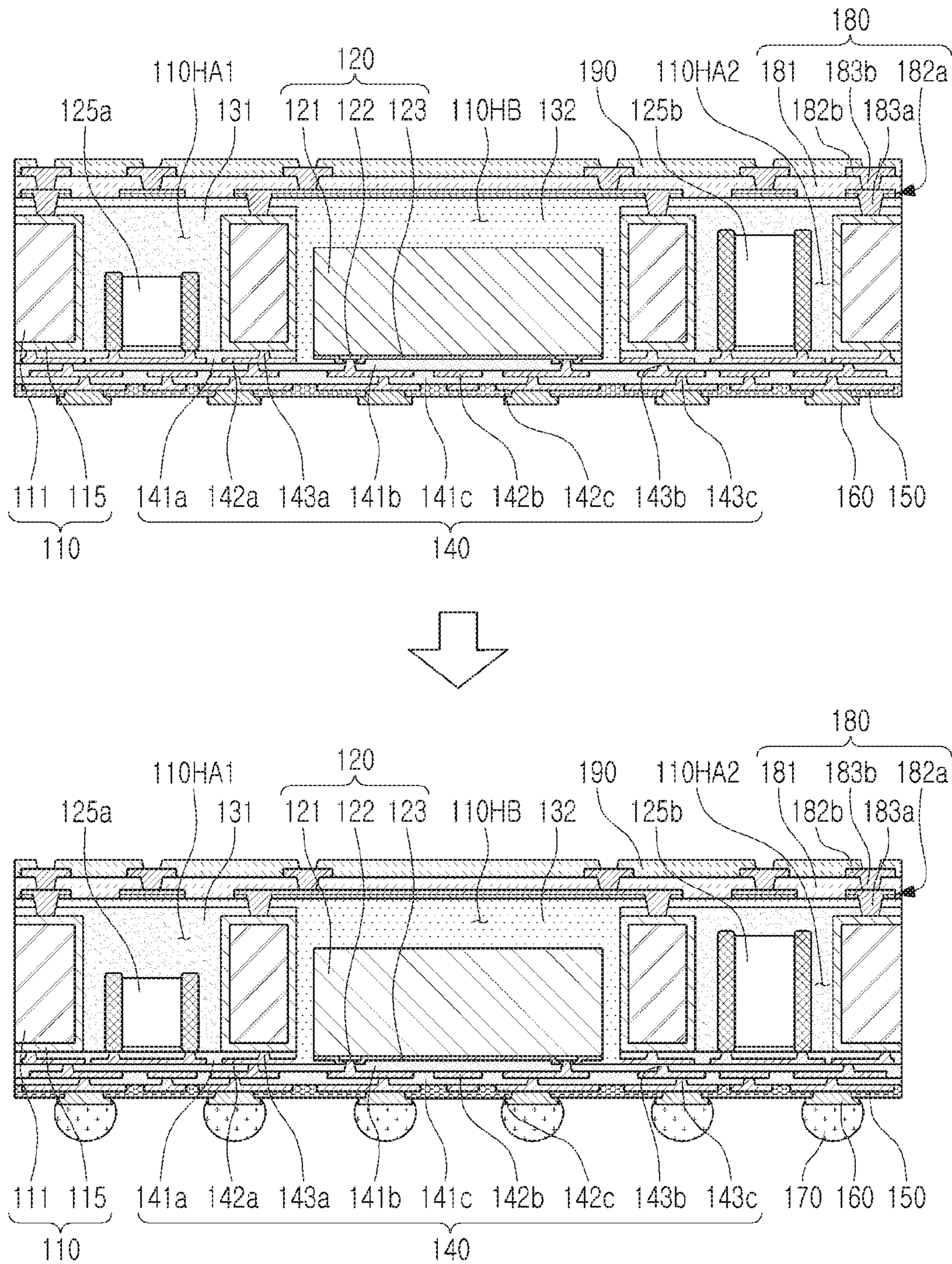


FIG. 11E

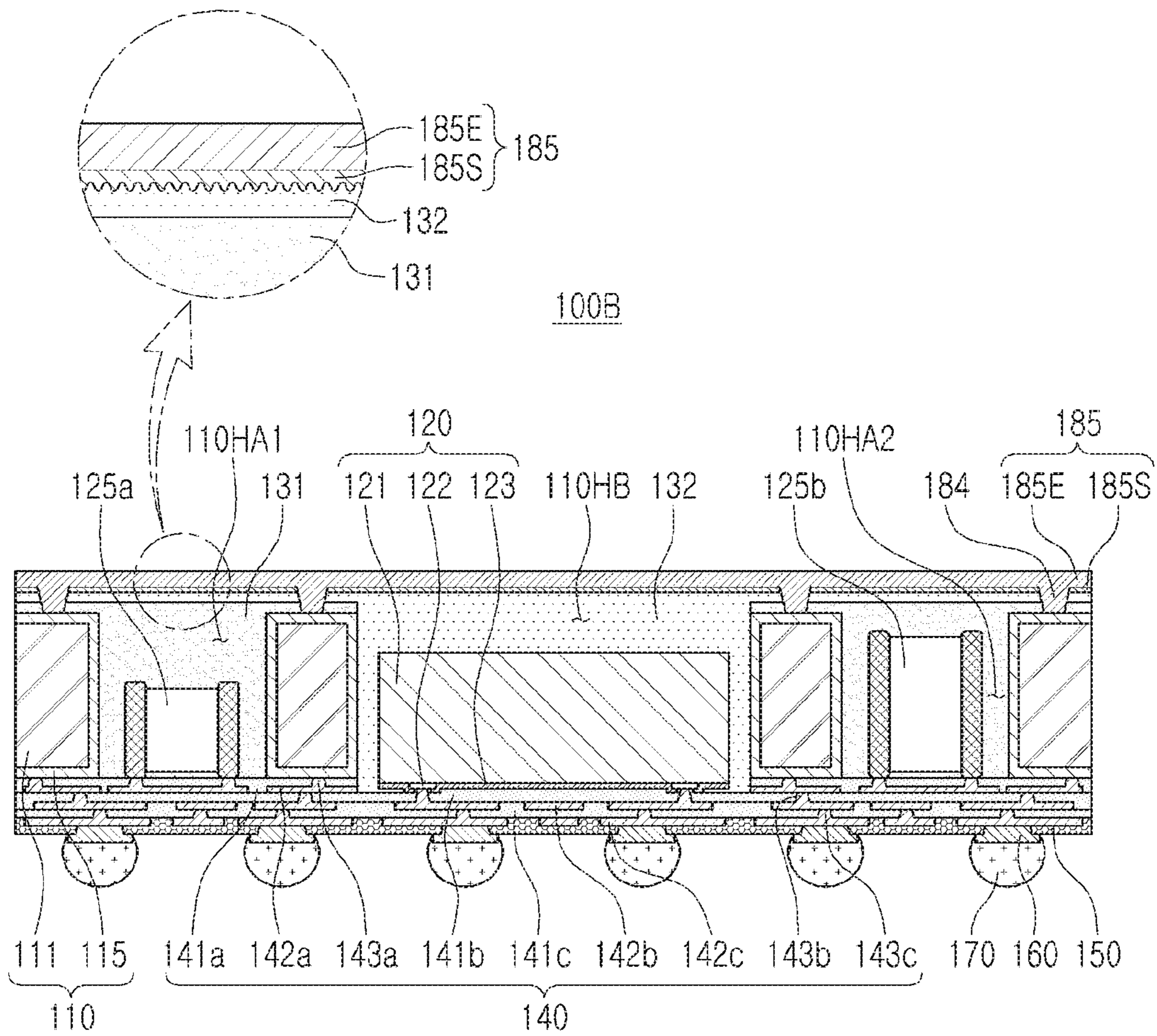


FIG. 12

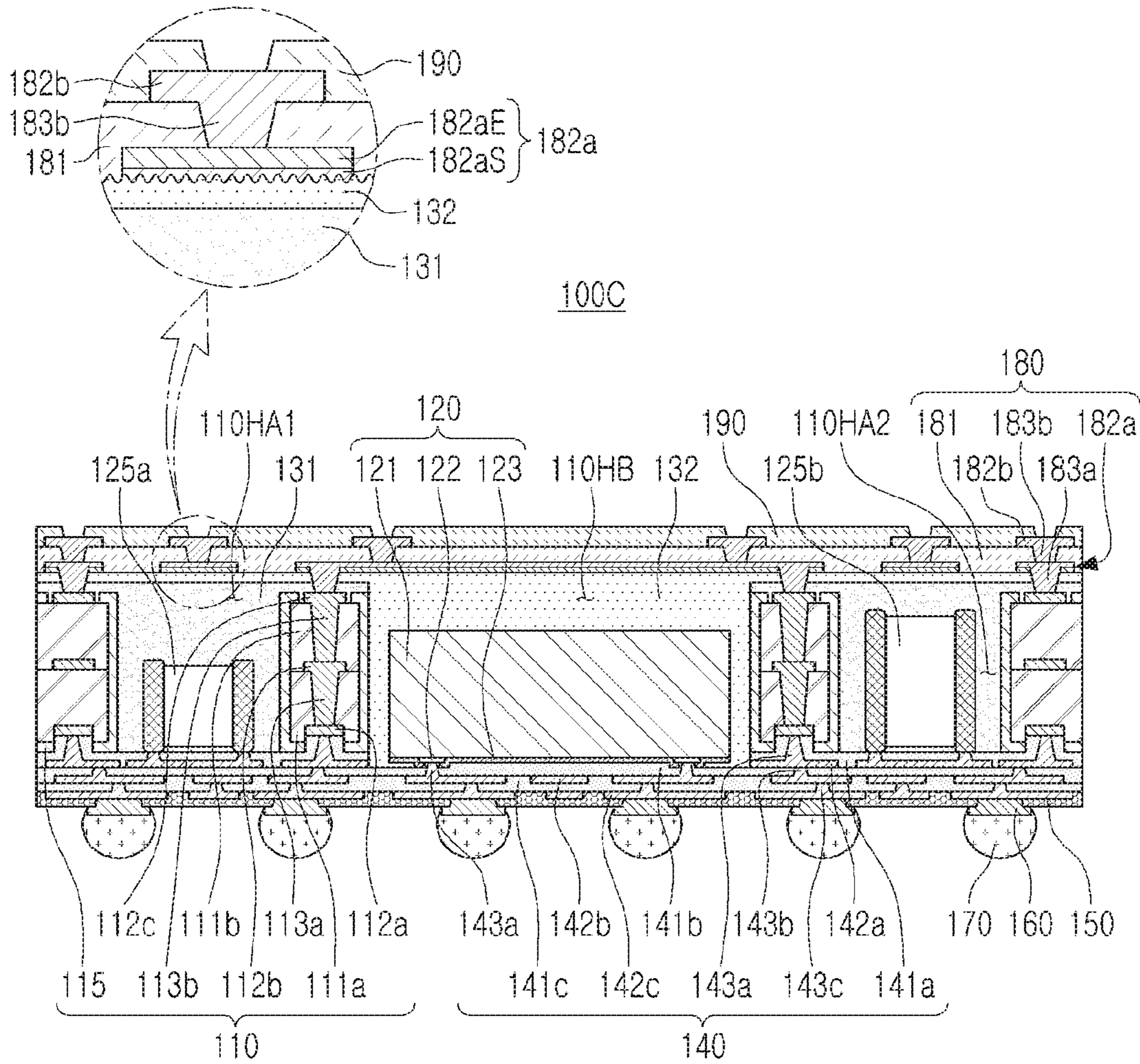


FIG. 13

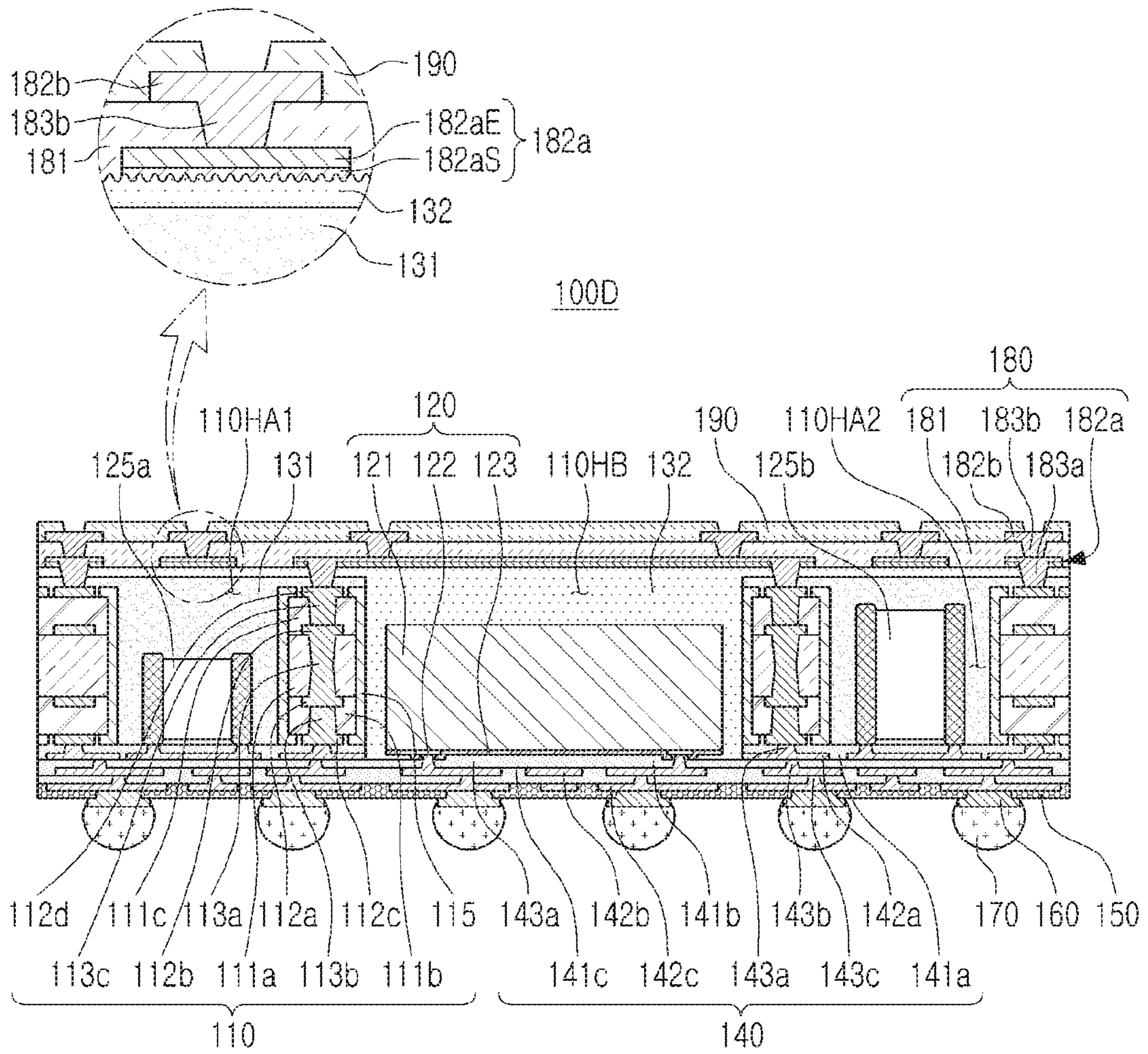


FIG. 14

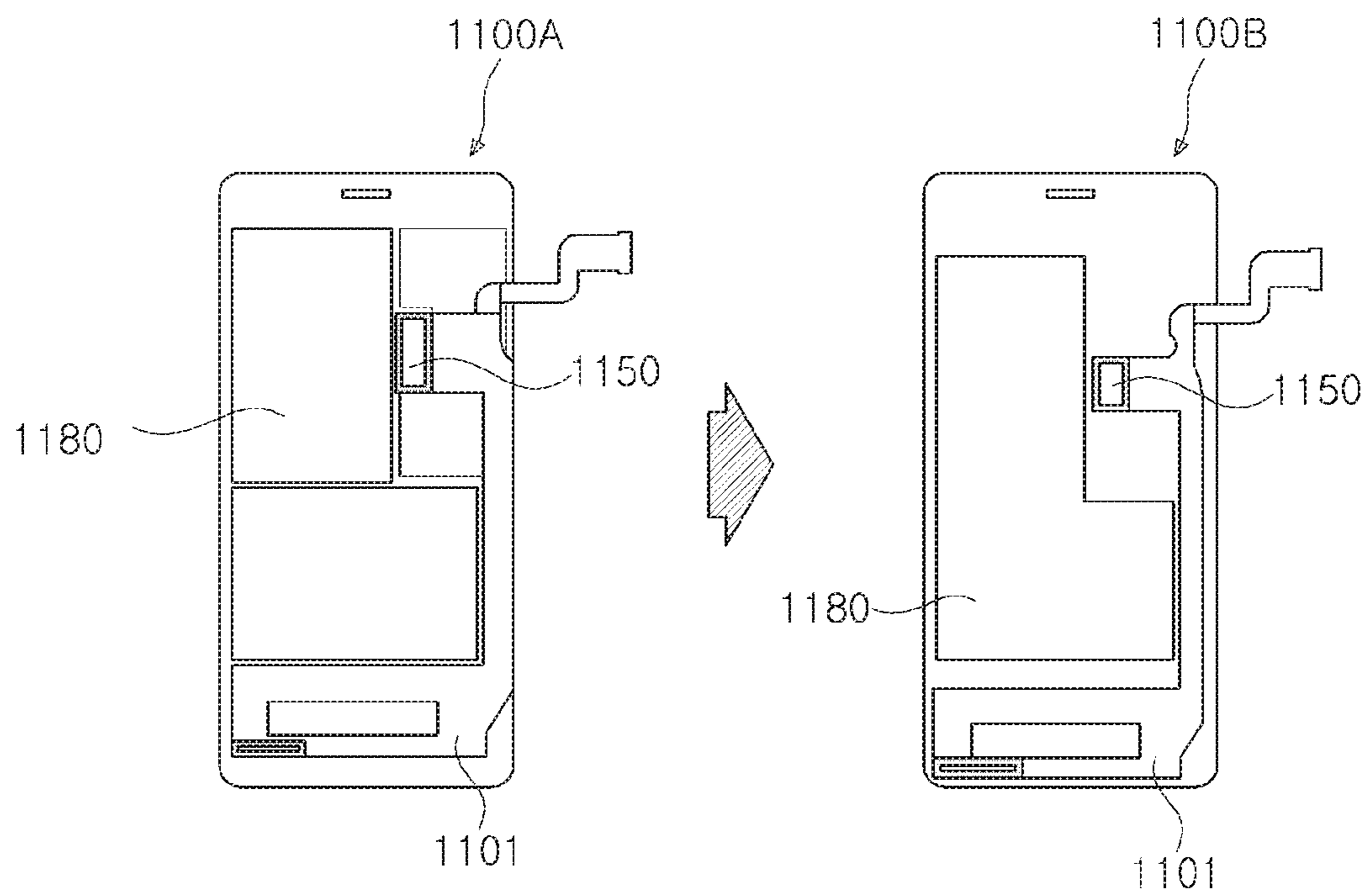


FIG. 15

1**SEMICONDUCTOR PACKAGE****CROSS-REFERENCE TO RELATED APPLICATION(S)**

This application claims benefit of priority to Korean Patent Application No. 10-2018-0128063 filed on Oct. 25, 2018 in the Korean Intellectual Property Office, the disclosure of which is incorporated herein by reference in its entirety.

BACKGROUND**1. Field**

The present disclosure relates to a semiconductor chip, for example, to a fan-out semiconductor package.

2. Description of Related Art

Semiconductor packages are continuously pursuing light, thin, short, and small shapes in terms of design, and pursuing a System in Package (SiP) structure which provides complexity and versatility in terms of functionality. To this end, a plurality of chips and components are mounted in a single package, and thus there is growing interest in techniques for shielding electromagnetic wave interference between components and for improving a heat dissipation function. In addition, a wiring structure for stacking packages is also used.

Particularly, when a metal layer is disposed in an upper portion of a semiconductor chip for EMI shielding, heat dissipation, wiring, or the like, it is common to form a chemical copper layer after removing a carrier from an encapsulant of a semiconductor chip. In this case, there may be problems in that adhesion between an encapsulant and a chemical copper layer is degraded, and a process becomes complicated.

SUMMARY

An aspect of the present disclosure is to provide a semiconductor package in which adhesion between a metal layer and an encapsulant is improved in an upper portion of a semiconductor chip, and to provide a method of manufacturing the semiconductor package using a simplified process.

According to an aspect of the present disclosure, in a semiconductor package, a metal layer is formed using a first conductive layer on an encapsulant having surface roughness.

For example, a semiconductor package includes a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface, and a first encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip. A metal layer is disposed on the first encapsulant, and includes a first conductive layer and a second conductive layer, sequentially stacked. A connection structure is disposed on the active surface of the semiconductor chip, and includes a first redistribution layer electrically connected to the connection pad. A lower surface of the first conductive layer is in contact with the first encapsulant and has first surface roughness, and an upper surface of the first conductive layer is in contact with the second conductive layer and has second surface roughness smaller than the first surface roughness.

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In accordance with another aspect of the disclosure, a semiconductor package may include a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface, and an encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip. A metal layer is disposed on the encapsulant, has at least a portion extended to overlap an upper portion of the semiconductor chip, and has a first conductive layer and a second conductive layer that are sequentially stacked. A via passes through a portion of the encapsulant and connects to the metal layer, and a connection structure is disposed on the active surface of the semiconductor chip and includes a redistribution layer electrically connected to the connection pad. A lower surface of the first conductive layer is in contact with the encapsulant and has roughness along a surface of the encapsulant, and an upper surface of the first conductive layer is in contact with the second conductive layer and is flat.

In accordance with a further aspect of the disclosure, a semiconductor package may include a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface, and an encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip. A metal layer is disposed on the encapsulant, and includes a first conductive layer and a second conductive layer, sequentially stacked in direct contact with each other. A connection structure is disposed on the active surface of the semiconductor chip, and includes a first redistribution layer electrically connected to the connection pad. Each of the first and second conductive layers extends to overlap, in a stacking direction of the semiconductor chip on the connection structure, with an entire upper surface of the semiconductor chip.

Other features and aspects will be apparent from the following detailed description, the drawings, and the claims.

BRIEF DESCRIPTION OF DRAWINGS

The above and other aspects, features, and advantages of the present disclosure will be more clearly understood from the following detailed description taken in conjunction with the accompanying drawings, in which:

FIG. 1 is a schematic block diagram illustrating an example of an electronic device system;

FIG. 2 is a schematic perspective view illustrating an example of an electronic device;

FIGS. 3A and 3B are schematic cross-sectional views illustrating a fan-in semiconductor package before and after being packaged;

FIG. 4 is a schematic cross-sectional view illustrating a packaging process of a fan-in semiconductor package;

FIG. 5 is a schematic cross-sectional view illustrating a fan-in semiconductor package mounted on an interposer substrate and ultimately mounted on a mainboard of an electronic device;

FIG. 6 is a schematic cross-sectional view illustrating a fan-in semiconductor package embedded in an interposer substrate and ultimately mounted on a mainboard of an electronic device;

FIG. 7 is a schematic cross-sectional view illustrating a fan-out semiconductor package;

FIG. 8 is a schematic cross-sectional view illustrating a fan-out semiconductor package mounted on a mainboard of an electronic device;

FIG. 9 is a schematic cross-sectional view illustrating an example of a semiconductor package;

FIG. 10 is a schematic plan view taken along line I-I' of the semiconductor package of FIG. 9;

FIGS. 11A to 11E are schematic process drawings illustrating steps of an example manufacturing process of the semiconductor package of FIG. 9;

FIG. 12 is a schematic cross-sectional view illustrating another example of a semiconductor package;

FIG. 13 is a schematic cross-sectional view illustrating another example of a semiconductor package;

FIG. 14 is a schematic cross-sectional view illustrating another example of a fan-out semiconductor package; and

FIG. 15 is a schematic plan view illustrating an effect of applying the semiconductor package according to the disclosure to an electronic device.

DETAILED DESCRIPTION

Hereinafter, embodiments of the present disclosure will be described as follows with reference to the attached drawings.

The present disclosure may, however, be exemplified in many different forms and should not be construed as being limited to the specific embodiments set forth herein. Rather, these embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the disclosure to those skilled in the art.

Throughout the specification, it will be understood that when an element, such as a layer, region or wafer (substrate), is referred to as being “on,” “connected to,” or “coupled to” another element, it can be directly “on,” “connected to,” or “coupled to” the other element or other elements intervening therebetween may be present. In contrast, when an element is referred to as being “directly on,” “directly connected to,” or “directly coupled to” another element, there may be no elements or layers intervening therebetween. Like numerals refer to like elements throughout. As used herein, the term “and/or” includes any and all combinations of one or more of the associated listed items.

It will be apparent that though the terms first, second, third, etc. may be used herein to describe various members, components, regions, layers and/or sections, these members, components, regions, layers and/or sections should not be limited by these terms. These terms are only used to distinguish one member, component, region, layer or section from another region, layer or section. Thus, a first member, component, region, layer or section discussed below could be termed a second member, component, region, layer or section without departing from the teachings of the exemplary embodiments.

Spatially relative terms, such as “above,” “upper,” “below,” and “lower” and the like, may be used herein for ease of description to describe one element’s relationship to another element(s) as shown in the figures. It will be understood that the spatially relative terms are intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. For example, if the device in the figures is turned over, elements described as “above,” or “upper” other elements would then be oriented “below,” or “lower” the other elements or features. Thus, the term “above” can encompass both the above and below orientations depending on a particular direction of the figures. The device may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein may be interpreted accordingly.

The terminology used herein describes particular embodiments only, and the present disclosure is not limited thereby. As used herein, the singular forms “a,” “an,” and “the” are intended to include the plural forms as well, unless the context clearly indicates otherwise. It will be further understood that the terms “comprises,” and/or “comprising” when used in this specification, specify the presence of stated features, integers, steps, operations, members, elements, and/or groups thereof, but do not preclude the presence or addition of one or more other features, integers, steps, operations, members, elements, and/or groups thereof.

Hereinafter, embodiments of the present disclosure will be described with reference to schematic views illustrating embodiments of the present disclosure. In the drawings, for example, due to manufacturing techniques and/or tolerances, modifications of the shape shown may be estimated. Thus, embodiments of the present disclosure should not be construed as being limited to the particular shapes of regions shown herein, for example, to include a change in shape results in manufacturing. The following embodiments may also be constituted by one or a combination thereof.

The contents of the present disclosure described below may have a variety of configurations and propose only an illustrative configuration herein, but are not limited thereto.

Electronic Device

FIG. 1 is a schematic block diagram illustrating an example of an electronic device system.

Referring to FIG. 1, an electronic device 1000 may receive a motherboard 1010. The mother board 1010 may include chip related components 1020, network related components 1030, other components 1040, or the like, physically or electrically connected thereto. These components may be connected to others to be described below to form various signal lines 1090.

The chip associated components 1020 may include a memory chip such as a volatile memory (for example, a dynamic random access memory (DRAM)), a non-volatile memory (for example, a read only memory (ROM)), a flash memory, or the like; an application processor chip such as a central processor (for example, a central processing unit (CPU)), a graphics processor (for example, a graphics processing unit (GPU)), a digital signal processor, a cryptographic processor, a microprocessor, a microcontroller, or the like; and a logic chip such as an analog-to-digital converter, an application-specific integrated circuit (ASIC), or the like, or the like. However, the chip associated components 1020 are not limited thereto, and may include other types of chip associated components. In addition, the chip-associated components 1020 may be combined with each other.

The network associated components 1030 may include protocols such as wireless fidelity (Wi-Fi) (Institute of Electrical And Electronics Engineers (IEEE) 802.11 family, or the like), worldwide interoperability for microwave access (WiMAX) (IEEE 802.16 family, or the like), IEEE 802.20, long term evolution (LTE), evolution data only (Ev-DO), high speed packet access+ (HSPA+), high speed downlink packet access+ (HSDPA+), high speed uplink packet access+ (HSUPA+), enhanced data GSM environment (EDGE), global system for mobile communications (GSM), global positioning system (GPS), general packet radio service (GPRS), code division multiple access (CDMA), time division multiple access (TDMA), digital enhanced cordless telecommunications (DECT), Bluetooth®, 3G, 4G, and 5G protocols, and any other wireless and wired protocols, designated after the abovementioned protocols. However, the network associated components

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1030 are not limited thereto, but may also include a variety of other wireless or wired standards or protocols. In addition, the network associated components **1030** may be combined with each other, together with the chip associated components **1020** described above.

Other components **1040** may include a high frequency inductor, a ferrite inductor, a power inductor, ferrite beads, a low temperature co-fired ceramic (LTCC), an electromagnetic interference (EMI) filter, a multilayer ceramic capacitor (MLCC), or the like. However, other components **1040** are not limited thereto, but may also include passive components used for various other purposes, or the like. In addition, other components **1040** may be combined with each other, together with the chip related components **1020** or the network related components **1030** described above.

Depending on a type of the electronic device **1000**, the electronic device **1000** includes other components that may or may not be physically or electrically connected to the mainboard **1010**. These other components may include, for example, a camera **1050**, an antenna **1060**, a display **1070**, a battery **1080**, an audio codec (not illustrated), a video codec (not illustrated), a power amplifier (not illustrated), a compass (not illustrated), an accelerometer (not illustrated), a gyroscope (not illustrated), a speaker (not illustrated), a mass storage unit (for example, a hard disk drive) (not illustrated), a compact disk (CD) drive (not illustrated), a digital versatile disk (DVD) drive (not illustrated), or the like. However, these other components are not limited thereto, but may also include other components used for various purposes depending on a type of electronic device **1000**, or the like.

The electronic device **1000** may be a smartphone, a personal digital assistant (PDA), a digital video camera, a digital still camera, a network system, a computer, a monitor, a tablet PC, a laptop PC, a netbook PC, a television, a video game machine, a smartwatch, an automotive component, or the like. However, the electronic device **1000** is not limited thereto, and may be any other electronic device able to process data.

FIG. 2 is a schematic perspective view illustrating an example of an electronic device.

Referring to FIG. 2, a semiconductor package may be used for various purposes in the various electronic devices **1000** as described above. For example, a printed circuit board **1110** may be accommodated in a body **1101** of a smartphone **1100**, and various electronic components **1120** may be physically or electrically connected to the printed circuit board **1110**. In addition, other components that may or may not be physically or electrically connected to the printed circuit board **1110**, such as a camera module **1130**, may be accommodated in the body **1101**. Some of the electronic components **1120** may be the chip related components, for example, a semiconductor package **1121**, but are not limited thereto. The electronic device is not necessarily limited to the smartphone **1100**, but may be other electronic devices as described above.

Semiconductor Package

Generally, numerous fine electrical circuits are integrated in a semiconductor chip. However, the semiconductor chip may not serve as a finished semiconductor product in itself, and may be damaged due to external physical or chemical impacts. Therefore, the semiconductor chip itself may not be used, but may be packaged and used in an electronic device, or the like, in a packaged state.

Here, semiconductor packaging is used due to the existence of a difference in a circuit width between the semiconductor chip and a mainboard of the electronic device in

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terms of electrical connections. In detail, a size of connection pads of the semiconductor chip and an interval between the connection pads of the semiconductor chip are very fine, but a size of component mounting pads of the mainboard used in the electronic device and an interval between the component mounting pads of the mainboard are significantly larger than those of the semiconductor chip. Therefore, it may be difficult to directly mount the semiconductor chip on the mainboard, and packaging technology for buffering a difference in a circuit width between the semiconductor chip and the mainboard is used.

A semiconductor package manufactured by the packaging technology may be classified as a fan-in semiconductor package or a fan-out semiconductor package depending on a structure and a purpose thereof.

The fan-in semiconductor package and the fan-out semiconductor package will hereinafter be described in more detail with reference to the drawings.

Fan-In Semiconductor Package

FIGS. 3A and 3B are schematic cross-sectional views illustrating states of a fan-in semiconductor package before and after being packaged.

FIG. 4 is schematic cross-sectional views illustrating a packaging process of a fan-in semiconductor package.

Referring to FIGS. 3 and 4, a semiconductor chip **2220** may be, for example, an integrated circuit (IC) in a bare state, including a body **2221** including silicon (Si), germanium (Ge), gallium arsenide (GaAs), or the like, connection pads **2222** formed on one surface of the body **2221** and including a conductive material such as aluminum (Al), or the like, and a passivation layer **2223** such as an oxide layer, a nitride layer, or the like, formed on one surface of the body **2221** and covering at least portions of the connection pads **2222**. In this case, since the connection pads **2222** may be significantly small, it may be difficult to mount the integrated circuit (IC) on an intermediate level printed circuit board (PCB) as well as on the mainboard of the electronic device, or the like.

Therefore, a connection structure **2240** may be formed depending on a size of the semiconductor chip **2220** on the semiconductor chip **2220** in order to redistribute the connection pads **2222**. The connection structure **2240** may be formed by forming an insulating layer **2241** on the semiconductor chip **2220** using an insulating material such as a photoimageable dielectric (PID) resin, forming via holes **2243** opening the connection pads **2222**, and then forming wiring patterns **2242** and vias **2243**. Then, a passivation layer **2250** protecting the connection structure **2240** may be formed, an opening **2251** may be formed, and an underbump metal layer **2260**, or the like, may be formed. That is, a fan-in semiconductor package **2200** including, for example, the semiconductor chip **2220**, the connection structure **2240**, the passivation layer **2250**, and the underbump metal layer **2260** may be manufactured through a series of processes.

As described above, the fan-in semiconductor package may have a package form in which all of the connection pads, for example, input/output (I/O) terminals, of the semiconductor chip are disposed inside the semiconductor chip, and may have excellent electrical characteristics and be produced at low cost. Therefore, many elements mounted in smartphones have been manufactured in a fan-in semiconductor package form. In detail, many elements mounted in smartphones have been developed to implement a rapid signal transfer while having a compact size.

However, since all I/O terminals need to be disposed inside the semiconductor chip in the fan-in semiconductor package, the fan-in semiconductor package has significant

spatial limitations. Therefore, it is difficult to apply this structure to a semiconductor chip having a large number of I/O terminals or a semiconductor chip having a compact size. In addition, due to the disadvantage described above, the fan-in semiconductor package may not be directly mounted and used on the mainboard of the electronic device. Here, even in a case in which a size of the I/O terminals of the semiconductor chip and an interval between the I/O terminals of the semiconductor chip are increased by a redistribution process, the size of the I/O terminals of the semiconductor chip and the interval between the I/O terminals of the semiconductor chip may not be sufficient to directly mount the fan-in semiconductor package on the mainboard of the electronic device.

FIG. 5 is a schematic cross-sectional view illustrating a case in which a fan-in semiconductor package is mounted on an interposer substrate and is ultimately mounted on a mainboard of an electronic device.

FIG. 6 is a schematic cross-sectional view illustrating a case in which a fan-in semiconductor package is embedded in an interposer substrate and is ultimately mounted on a mainboard of an electronic device.

Referring to FIGS. 5 and 6, in a fan-in semiconductor package **2200**, connection pads **2222**, that is, I/O terminals, of a semiconductor chip **2220** may be redistributed through an interposer substrate **2301**, and the fan-in semiconductor package **2200** may ultimately be mounted on a mainboard **2500** of an electronic device in a state in which it is mounted on the interposer substrate **2301**. In this case, solder balls **2270**, and the like, may be fixed by an underfill resin **2280**, or the like, and an outer side of the semiconductor chip **2220** may be covered with a molding material **2290**, or the like. Alternatively, a fan-in semiconductor package **2200** may be embedded in a separate interposer substrate **2302**, connection pads **2222**, that is, I/O terminals, of the semiconductor chip **2220** may be redistributed by the interposer substrate **2302** in a state in which the fan-in semiconductor package **2200** is embedded in the interposer substrate **2302**, and the fan-in semiconductor package **2200** may be ultimately mounted on a mainboard **2500** of an electronic device.

As described above, it may be difficult to directly mount and use the fan-in semiconductor package on the mainboard of the electronic device. Therefore, the fan-in semiconductor package may be mounted on the separate interposer substrate and be then mounted on the mainboard of the electronic device through a packaging process or may be mounted and used on the mainboard of the electronic device in a state in which it is embedded in the interposer substrate.

Fan-Out Semiconductor Package

FIG. 7 is a schematic cross-sectional view illustrating a fan-out semiconductor package.

Referring to FIG. 7, in a fan-out semiconductor package **2100**, for example, an outer side of a semiconductor chip **2120** may be protected by an encapsulant **2130**, and connection pads **2122** of the semiconductor chip **2120** may be redistributed outwardly of the semiconductor chip **2120** by a connection structure **2140**. In this case, a passivation layer **2202** may further be formed on the connection structure **2140**, and an underbump metal layer **2160** may further be formed in openings of the passivation layer **2202**. Solder balls **2170** may further be formed on the underbump metal layer **2160**. The semiconductor chip **2120** may be an integrated circuit (IC) including a body **2121**, the connection pads **2122**, a passivation layer (not illustrated), and the like. The connection structure **2140** may include an insulating layer **2141**, redistribution layers **2142** formed on the insu-

lating layer **2141**, and vias **2143** electrically connecting the connection pads **2122** and the redistribution layers **2142** to each other.

As described above, the fan-out semiconductor package may have a form in which I/O terminals of the semiconductor chip are redistributed and disposed outwardly of the semiconductor chip through the connection structure formed on the semiconductor chip. As described above, in the fan-in semiconductor package, all I/O terminals of the semiconductor chip need to be disposed inside the semiconductor chip. Therefore, when a size of the semiconductor chip is decreased, a size and a pitch of balls need to be decreased, such that a standardized ball layout may not be used in the fan-in semiconductor package. On the other hand, the fan-out semiconductor package has the form in which the I/O terminals of the semiconductor chip are redistributed and disposed outwardly of the semiconductor chip through the connection structure formed on the semiconductor chip as described above. Therefore, even in a case that a size of the semiconductor chip is decreased, a standardized ball layout may be used in the fan-out semiconductor package as it is, such that the fan-out semiconductor package may be mounted on the mainboard of the electronic device without using a separate printed circuit board, as described below.

FIG. 8 is a schematic cross-sectional view illustrating a case in which a fan-out semiconductor package is mounted on a mainboard of an electronic device.

Referring to FIG. 8, a fan-out semiconductor package **2100** may be mounted on a mainboard **2500** of an electronic device through solder balls **2170**, or the like. That is, as described above, the fan-out semiconductor package **2100** includes the connection structure **2140** formed on the semiconductor chip **2120** and capable of redistributing the connection pads **2122** to a fan-out region that is outside of a size of the semiconductor chip **2120**, such that the standardized ball layout may be used in the fan-out semiconductor package **2100** as it is. As a result, the fan-out semiconductor package **2100** may be mounted on the mainboard **2500** of the electronic device without using a separate interposer substrate, or the like.

As described above, since the fan-out semiconductor package may be mounted on the mainboard of the electronic device without using the separate interposer substrate, the fan-out semiconductor package may be implemented at a thickness lower than that of the fan-in semiconductor package using the interposer substrate. Therefore, the fan-out semiconductor package may be miniaturized and thinned. In addition, the fan-out semiconductor package has excellent thermal characteristics and electrical characteristics, such that it is particularly appropriate for a mobile product. Therefore, the fan-out electronic component package may be implemented in a form more compact than that of a general package-on-package (POP) type using a printed circuit board (PCB), and may solve a problem due to the occurrence of a warpage phenomenon.

Meanwhile, the fan-out semiconductor package refers to package technology for mounting the semiconductor chip on the mainboard of the electronic device, or the like, as described above, and protecting the semiconductor chip from external impacts, and is a concept different from that of a printed circuit board (PCB) such as an interposer substrate, or the like, having a scale, a purpose, and the like, different from those of the fan-out semiconductor package, and having the fan-in semiconductor package embedded therein.

Hereinafter, a semiconductor package, in which adhesion between a metal layer and an encapsulant is improved in an

upper portion of a semiconductor chip, and which can be manufactured by a simplified process, will be described with reference to the drawings.

FIG. 9 is a schematic cross-sectional view illustrating an example of a semiconductor package.

FIG. 10 is a schematic plan view taken along line I-I' of the semiconductor package of FIG. 9.

Referring to FIGS. 9 and 10, a semiconductor package 100A according to an embodiment may include a frame 110 having first through-holes 110HA1 and 110HA2 and a second through-hole 110HB, at least one passive component 125a and at least one passive component 125b disposed in the first through-holes 110HA1 and 110HA2 of the frame 110, a semiconductor chip 120 disposed in the second through-hole 110HB of the frame 110 and having an active surface on which the connection pad 122 is disposed and an inactive surface opposing the active surface, a first encapsulant 131 sealing at least portions of the frame 110 and the passive components 125a and 125b, a second encapsulant 132 sealing at least portions of the frame 110 and the semiconductor chip 120, a connection structure 140 disposed on the frame 110, lower surfaces of the passive components 125a and 125b, and the active surface of the semiconductor chip 120, a backside connection structure 180 disposed on the second encapsulant 132 and including at least one metal layer 182a and 182b, a first passivation layer 150 disposed on the connection structure 140, an underbump metal layer 160 disposed in an opening of the first passivation layer 150, an electrical connection metal 170 disposed on the first passivation layer 150 and connected to the underbump metal layer 160, and a second passivation layer 190 disposed on the backside connection structure 180.

The backside connection structure 180 may include a first metal layer 182a disposed on the second encapsulant 132, a first backside via 183a passing through the first and second encapsulants 131 and 132 and connecting the frame 110 to the first metal layer 182a, a backside insulating layer 181 disposed on the first metal layer 182a, a second metal layer 182b disposed on the backside insulating layer 181, and a second backside via 183b connecting the first metal layer 182a to the second metal layer 182b. At least a portion of the first metal layer 182a may be disposed to overlap the semiconductor chip 120 in an upper portion of the semiconductor chip 120.

In detail, the first metal layer 182a, disposed to be in contact with an upper surface of the second encapsulant 132, includes a first conductive layer 182aS and a second conductive layer 182aE, vertically stacked. A lower surface of the first conductive layer 182aS is in direct contact with an upper surface of the second encapsulant 132, and has roughness along an upper surface of the second encapsulant 132, that is, surface roughness. The upper surface of the second encapsulant 132 may have roughness formed intentionally for improving a bonding force or formed according to characteristics of a material of the second encapsulant 132. Thus, a lower surface of the first conductive layer 182aS may have first surface roughness. An upper surface of the first conductive layer 182aS is in direct contact with the second conductive layer 182aE, and may have second surface roughness, smaller than the first surface roughness. The second surface roughness may have a small value, close to zero. For example, the second surface roughness may be equal to or less than about 2 μm , particularly, about 0.5 μm , but is not limited thereto. Thus, the upper surface of the first conductive layer 182aS may be a flat and smooth surface when viewed with naked eyes. The first surface roughness

may vary according to embodiments and may be in a range, for example, from a few micrometers to several millimeters. An upper surface of the second encapsulant 132 may have surface roughness equal to or similar to the first surface roughness. Since the second conductive layer 182aE generally has morphology according to morphology of a surface on which the second conductive layer is formed, a lower surface and an upper surface of the second conductive layer 182aE may have surface roughness, equal to or similar to the second surface roughness.

The first conductive layer 182aS may be, for example, a copper foil layer including a copper (Cu) foil, and the second conductive layer 182aE may be an electroplated layer formed using the first conductive layer 182aS as a seed layer. A thickness of the second conductive layer 182aE may be greater than a thickness of the first conductive layer 182aS, but is not limited thereto. For example, the second conductive layer 182aE may be a layer including copper (Cu), in a manner similar to the first conductive layer 182aS, but is not limited thereto. The second conductive layer may include a conductive material such as aluminum (Al), silver (Ag), tin (Sn), gold (Au), nickel (Ni), lead (Pb), titanium (Ti), or alloys thereof. The first conductive layer 182aS may be a copper foil, forming a portion of a carrier, during a manufacturing process of the semiconductor package 100A. As the first conductive layer 182aS, the copper foil, is disposed on the second encapsulant 132, adhesion may be improved, as compared with the case in which chemical copper is disposed on the second encapsulant 132 by electroless plating. Moreover, since a portion of the carrier, used during a manufacturing process, is used as a seed layer for plating, a manufacturing process may be simplified.

The respective components included in the semiconductor package 100A according to an embodiment will hereinafter be described in more detail.

The frame 110 may improve rigidity of the semiconductor package 100A depending on certain materials, and serve to secure uniformity of thicknesses of the first and second encapsulants 131 and 132. The frame 110 has a plurality of first and second through-holes 110HA1 and 110HA2, and 110HB. The first and second through-holes 110HA1 and 110HA2, and 110HB may be disposed to be physically spaced apart from each other. The first through-holes 110HA1 and 110HA2 may pass through the frame 110, while the passive components 125a and 125b may be disposed in the first through-holes 110HA1 and 110HA2. As illustrated in FIG. 9, the passive components 125a and 125b may be disposed to be spaced apart from wall surfaces of the first through-holes 110HA1 and 110HA2 by a predetermined distance, and may be surrounded by the wall surfaces of the first through-holes 110HA1 and 110HA2, but are not limited thereto. The second through-hole 110HB may pass through the frame 110 and the first encapsulant 131, while the semiconductor chip 120 may be disposed in the second through-hole 110HB. The semiconductor chip 120 may be disposed to be spaced apart from a wall surface of the second through-hole 110HB by a predetermined distance, and may be surrounded by the wall surface of the second through-hole 110HB. However, such a form is only an example and may be variously modified to have other forms, and another function may be performed depending on such a form. The frame 110 may optionally be omitted, but the case having the frame 110 may be more advantageous in securing the board level reliability as intended in the present disclosure.

The frame 110 may include a frame insulating layer 111 and a frame metal layer 115 surrounding the frame insulating layer 111. An insulating material may be used as the

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material of the frame insulating layer **111**. In this case, the insulating material may be a thermosetting resin such as an epoxy resin, a thermoplastic resin such as a polyimide resin, an insulating material in which the thermosetting resin or the thermoplastic resin is impregnated together with an inorganic filler in a core material such as a glass fiber (or a glass cloth or a glass fabric), for example, prepreg, Ajinomoto Build-up Film (ABF), FR-4, Bismaleimide Triazine (BT), or the like. Such a frame **110** may serve as a supporting member.

The frame metal layer **115** may be disposed in an inner side wall of each of the first through-holes **110HA1** and **110HA2** and the second through-hole **110HB**. As illustrated in FIG. **10**, the frame metal layer **115** may be disposed to surround each of the passive components **125a** and **125b**, and the semiconductor chip **120**. The frame metal layer **115** may be introduced to improve an electromagnetic interference (EMI) shielding effect and a heat dissipation effect of the passive components **125a** and **125b** and the semiconductor chip **120**. The frame metal layer **115** may include a conductive material such as copper (Cu), aluminum (Al), silver (Ag), tin (Sn), gold (Au), nickel (Ni), lead (Pb), titanium (Ti), or alloys thereof. The frame metal layer **115** may be formed using a plating process, and may be formed of a seed layer and a conductor layer. The frame metal layer **115** may be used as a ground. In this case, the frame metal layer may be electrically connected to a ground pattern layer in the connection structure **140**.

The semiconductor chip **120** may be an integrated circuit (IC) providing in an amount of several hundred to several million or more elements integrated in a single chip. The IC may be, for example, a processor chip such as a central processor (for example, a central processing unit (CPU)), a graphics processor (for example, a graphics processing unit (GPU)), a field programmable gate array (FPGA), a digital signal processor, a cryptographic processor, a microprocessor, a microcontroller, or the like, in detail, an application processor (AP). However, the present disclosure is not limited thereto, and the semiconductor chip may be a logic chip such as an analog-to-digital converter (ADC), an application-specific integrated circuit (ASIC), or the like, or a memory chip such as a volatile memory (for example, a dynamic random access memory (DRAM)), a non-volatile memory (for example, a read only memory (ROM)), a flash memory, or the like, but is not limited thereto. Moreover, these chip related components are also combined.

In the semiconductor chip **120**, a side, on which connection pad **122** is disposed, is referred to as an active surface, and the opposite side is referred to as an inactive surface. The semiconductor chip **120** may be formed on the basis of an active wafer. In this case, a base material of a body **121** of the semiconductor chip **120** may be silicon (Si), germanium (Ge), gallium arsenide (GaAs), or the like. Various circuits may be formed on the body **121**. The connection pads **122** may electrically connect the semiconductor chip **120** to other components. A material of each of the connection pads **122** may be a conductive material such as aluminum (Al), or the like. A passivation layer **123** exposing the connection pads **122** may be formed on the body **121**, and may be an oxide layer, a nitride layer, or the like, or a double layer of an oxide layer and a nitride layer.

Each of the passive components **125a** and **125b** may be a capacitor such as a multilayer ceramic capacitor (MLCC) or a low inductance chip capacitor (LICC), an inductor such as a power inductor, a bead, or the like, independently. The passive components **125a** and **125b** may have different sizes and thicknesses. Moreover, each of the passive components

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125a and **125b** may have a thickness different from a thickness of the semiconductor chip **120**. In the semiconductor package **100A** according to an embodiment, the passive components **125a** and **125b** and the semiconductor chip **120** are sealed in different processes, so a problem of defects due to such thickness variations may be significantly reduced. The number of the passive components **125a** and **125b** are not particularly limited, and may be more or less than that illustrated in the drawings.

The first encapsulant **131** fills at least portions of the first through-holes **110HA1** and **110HA2**, and may seal one or more passive components **125a** and **125b**. An encapsulation form of the first encapsulant **131** is not particularly limited, but may be a form in which the first encapsulant **131** surrounds at least portions of the passive components **125a** and **125b**. The first encapsulant **131** may cover at least portions of an upper surface and a lower surface of the passive components **125a** and **125b**, and may fill at least a portion of a space between wall surfaces of the first through-holes **110HA1** and **110HA2** and side surfaces of a plurality of passive components **125a** and **125b**. The first encapsulant **131** is extended to the frame **110** to be disposed on the frame **110**, and may be in contact with an upper surface of the frame metal layer **115**.

The second encapsulant **132** may fill at least a portion of the second through-hole **110HB**, while sealing the semiconductor chip **120**. An encapsulation form of the second encapsulant **132** is not particularly limited, but may be a form in which the second encapsulant **132** surrounds at least a portion of the semiconductor chip **120**. In this case, the second encapsulant **132** may cover at least portions of the frame **110** and an inactive surface of the semiconductor chip **120**, and fill at least a portion of a space between a wall surface of the second through-hole **110HB** and a side surface of the semiconductor chip **120**. Meanwhile, the second encapsulant **132** may fill the second through-hole **110HB** to thus serve as an adhesive for fixing the semiconductor chip **120** and reduce buckling at the same time, depending on certain materials. The second encapsulant **132** is disposed in an upper portion of the semiconductor chip **120** as described above, is extended to upper portions of the passive components **125a** and **125b** and the frame **110**, and may be disposed on the first encapsulant **131**, on the passive components **125a** and **125b** and the frame **110**. Thus, the first and second encapsulants **131** and **132** are stacked sequentially and arranged on the passive components **125a** and **125b** and the frame **110**, and the second encapsulant **132** may be only disposed on the semiconductor chip **120**.

The first and second encapsulants **131** and **132** may include an insulating material. The insulating material may be a material containing an inorganic filler and an insulating resin, for example, a thermosetting resin such as an epoxy resin, a thermoplastic resin such as a polyimide, or a resin in which a reinforcement such as an inorganic filler is contained in the thermosetting resin or the thermoplastic resin, in detail, an Ajinomoto build-up film (ABF), an FR-4 resin, a bismaleimide triazine (BT) resin, a resin, or the like. Moreover, an epoxy molding compound (EMC), a photo imageable encapsulant (PIE), or the like, may be used therefor. As needed, a material in which an insulating resin such as the thermosetting resin or the thermoplastic resin is impregnated in an inorganic filler together with a core material such as a glass fiber, may be used. The first and second encapsulants **131** and **132** may include the same or different materials as each other.

The connection structure **140** may redistribute the connection pads **122** of the semiconductor chip **120**. Several

tens to several hundreds of connection pads **122** of the semiconductor chip **120** having various functions may be redistributed by the connection structure **140**, and may be physically or electrically externally connected through the electrical connection metal **170** depending on functions. The connection structure **140** may include a number of insulating layers, redistribution layers, and vias, greater than the number illustrated in the drawings.

The connection structure **140** may include a first insulating layer **141a** disposed on the frame **110** and the passive components **125a** and **125b**, a first redistribution layer **142a** disposed on the first insulating layer **141a**, and a first via **143a** connecting the first redistribution layer **142a**, the passive components **125a** and **125b**, and the frame metal layer **115**. The connection structure **140** may further include the second insulating layer **141b** disposed on the first insulating layer **141a**, the second redistribution layer **142b** disposed on the second insulating layer **141b**, and the second via **143b** connecting the first and second redistribution layers **142a** and **142b** or connecting the connection pad **122** of the semiconductor chip **120** and the second redistribution layer **142b** while passing through the second insulating layer **141b**. The connection structure **140** may also include a third insulating layer **141c** disposed on the second insulating layer **141b**, a third redistribution layer **142c** disposed on the third insulating layer **141c**, and a third via **143c** connecting the second and third redistribution layers **142b** and **142c** while passing through the third insulating layer **141c**. The first redistribution layer **142a** is electrically connected to the passive components **125a** and **125b**, and the second and third redistribution layers **142b** and **142c** are electrically connected to the connection pad **122** of the semiconductor chip **120** and the passive components **125a** and **125b**. The connection structure **140** may include a number of insulating layers, redistribution layers, and vias, greater or smaller than the number illustrated in the drawings.

A material of each of the insulating layers **141a**, **141b**, and **141c** may be an insulating material. In this case, a photosensitive insulating material such as a PID resin may also be used as the insulating material. That is, each of the insulating layers **141a**, **141b**, and **141c** may be a photosensitive insulating layer. When the insulating layers **141a**, **141b**, and **141c** have photosensitive properties, the insulating layers **141a**, **141b**, and **141c** may be formed to have a smaller thickness, and a fine pitch of each of the vias **143a**, **143b**, and **143c** may be achieved more easily. Each of the insulating layers **141a**, **141b**, and **141c** may be a photosensitive insulating layer including an insulating resin and an inorganic filler. When the insulating layers **141a**, **141b**, and **141c** are multiple layers, materials of the insulating layers **141a**, **141b**, and **141c** may be the same as each other, and may alternately be different from each other. When the insulating layers **141a**, **141b**, and **141c** are multiple layers, the insulating layers **141a**, **141b**, and **141c** may be integrated with each other depending on processes, so that a boundary therebetween may not be readily apparent. The number of insulating layers, greater than those illustrated in the drawings, may be provided.

The second and third redistribution layers **142b** and **142c**, among the redistribution layers **142a**, **142b**, and **142c**, may substantially serve to redistribute the connection pads **122**, and a formation material thereof may be a conductive material such as copper (Cu), aluminum (Al), silver (Ag), tin (Sn), gold (Au), nickel (Ni), lead (Pb), titanium (Ti), or alloys thereof. The redistribution layers **142a**, **142b**, and **142c** may perform various functions depending on designs of corresponding layers. For example, the redistribution

layers may include ground (GND) patterns, and may include power (PWR) patterns, signal (S) patterns, and the like. Here, the signal (S) patterns may include various signals except for the ground (GND) signals, the power (PWR) signals, and the like, such as data signals, and the like. Moreover, the redistribution layers **142a**, **142b**, and **142c** may include via pad patterns, electrical connection metal pad patterns, and the like.

The vias **143a**, **143b**, and **143c** may electrically connect the redistribution layers **142a**, **142b**, and **142c**, the connection pads **122**, the passive components **125a** and **125b**, and the like, formed on different layers, to each other, resulting in an electrical path in the semiconductor package **100A**. A material of each of the vias **143a**, **143b**, and **143c** may be a conductive material such as copper (Cu), aluminum (Al), silver (Ag), tin (Sn), gold (Au), nickel (Ni), lead (Pb), titanium (Ti), or alloys thereof. Each of the vias **143a**, **143b**, and **143c** may be completely filled with a conductive material, or the conductive material may be formed along a wall of a via. In addition, the vias **143a**, **143b**, and **143c** may have various shapes, such as a tapered shape, a cylindrical shape, and the like.

A backside connection structure **180** may be disposed on the second encapsulant **132** to cover the semiconductor chip **120** and the passive components **125a** and **125b**. The backside connection structure **180** may be electrically connected to the connection pad **122** of the semiconductor chip **120** and/or the connection structure **140**. Moreover, the backside connection structure **180** may electrically connect a semiconductor chip or a semiconductor package, mounted on an upper portion of a package, to the connection structure **140** in a lower portion of the package. In the backside connection structure **180**, the first metal layer **182a** may be connected to the frame metal layer **115** of the frame **110** through the first backside via **183a**, passing through the first and second encapsulants **131** and **132**. The first backside via **183a** may have a form of passing through the first conductive layer **182aS** of the first metal layer **182a** to be connected to the second conductive layer **182aE**. At least a portion of the second metal layer **182b** may be exposed upwardly through the second passivation layer **190** for connection with a configuration in an upper portion. By the first and second metal layers **182a** and **182b**, as well as the first and second backside vias **183a** and **183b**, the semiconductor chip **120** and the passive components **125a** and **125b** are surrounded, so an EMI shielding effect and a heat dissipation effect of the package may be further improved. The first and second metal layers **182a** and **182b**, and the first and second backside vias **183a** and **183b** may include a conductive material such as copper (Cu), aluminum (Al), silver (Ag), tin (Sn), gold (Au), nickel (Ni), lead (Pb), titanium (Ti), or alloys thereof. A material of the backside insulating layer **181** may be an insulating material. In this case, the insulating material may be the insulating material described above or a photosensitive insulating material such as a PID resin, in a manner similar to the insulating layers **141a**, **141b**, and **141c** of the connection structure **140**.

The first passivation layer **150** may protect the connection structure **140** from external physical or chemical damage. The first passivation layer **150** may have one or more opening(s) exposing at least a portion of the third redistribution layer **142c** of the connection structure **140**. The number of openings, formed in the first passivation layer **150**, may be several tens to several thousands. A material of the first passivation layer **150** is not particularly limited. For example, an insulating material may be used as the material of the first passivation layer. In this case, the insulating

material may be a thermosetting resin such as an epoxy resin, a thermoplastic resin such as a polyimide resin, a resin in which the thermosetting resin or the thermoplastic resin is mixed with an inorganic filler or is impregnated together with an inorganic filler in a core material such as a glass fiber (or a glass cloth or a glass fabric), for example, prepreg, ABF, FR-4, BT, or the like. Alternatively, a solder resist may also be used therefor. A second passivation layer **190** is also formed on the backside connection structure **180** to protect the backside connection structure **180**. The first passivation layer **150** and the second passivation layer **190** include the same material, thereby serving to control a coefficient of thermal expansion (CTE) due to an effect of symmetry.

The underbump metal layer **160** may improve connection reliability of the electrical connection metal **170** to improve board level reliability of the semiconductor package **100A**. The underbump metal layer **160** may be connected to the third redistribution layer **142c** of the connection structure **140**, exposed through the openings of the first passivation layer **150**. The underbump metal layer **160** may be formed in the openings of the first passivation layer **150** by any appropriate metallization method using any appropriate conductive material such as a metal, but is not limited thereto.

The electrical connection metal **170** physically and/or electrically connects the semiconductor package **100A** to an external power source. For example, the semiconductor package **100A** may be mounted on the mainboard of the electronic device through the electrical connection metal **170**. The electrical connection metal **170** may be formed of a conductive material, for example, a solder or the like. However, this is only an example, and a material of each of the electrical connection metal **170** is not particularly limited thereto. Each of the electrical connection metals **170** may be a land, a ball, a pin, or the like. The electrical connection metals **170** may be formed as a multilayer or single layer structure. When the electrical connection metal includes the plurality of layers, the electrical connection metal includes a copper pillar and a solder. When the electrical connection metal includes the single layer, the electrical connection metal includes a tin-silver solder or copper. However, the electrical connection metal is only an example, and the present disclosure is not limited thereto. The number, an interval, a disposition form, and the like, of the electrical connection metals **170** are not particularly limited, but may be sufficiently modified depending on design particulars. For example, the electrical connection metals **170** may be provided in an amount of several tens to several thousands, or may be provided in an amount of several tens to several thousands or more or several tens to several thousands or less.

At least one of the electrical connection metals **170** may be disposed in a fan-out region of the semiconductor chip **120**. The fan-out region refers to a region except for (or outside of) a region in which the semiconductor chip **120** is disposed. The fan-out package may have excellent reliability as compared to a fan-in package, may allow a plurality of input/output (I/O) terminals to be implemented, and may facilitate a 3D interconnection. In addition, as compared to a ball grid array (BGA) package, a land grid array (LGA) package, or the like, the fan-out package may be manufactured to have a small thickness, and may have price competitiveness.

FIGS. **11A** to **11E** are schematic process drawings illustrating a manufacturing example of the semiconductor package of FIG. **9**.

Referring to FIG. **11A**, a frame **110** is prepared, first through-holes **110HA1** and **110HA2**, passing through an

upper surface and a lower surface of the frame **110**, are formed, a frame metal layer **115** is formed on an inner side wall and an upper surface and a lower surface of the first through-holes **110HA1** and **110HA2**, a first adhesive film **210** is attached to one side of the frame **110**, and passive components **125a** and **125b** are disposed on the first adhesive film **210** in the first through-holes **110HA1** and **110HA2**. Then, the first encapsulant **131** is used to seal the passive components **125a** and **125b** and, optionally, an upper surface of the frame **110**. The first adhesive film **210** is removed, and the first insulating layer **141a**, the first redistribution layer **142a**, and the first via **143a**, which are a portion of the connection structure **140**, may be formed in a lower portion of the passive components **125a** and **125b** and on lower surfaces of the frame **110** and first encapsulant **131**. The first encapsulant **131** may seal at least upper surfaces of the frame **110** and the passive components **125a** and **125b**, while filling a space in the first through-holes **110HA1** and **110HA2**.

Referring to FIG. **11B**, a second adhesive film **215** is attached to one side of the frame **110** (e.g., attached to a lower surface of the first redistribution layer **142a**), a second through-hole **110HB**, passing through an upper surface and a lower surface of the frame **110**, is formed (and, optionally, the frame metal layer **115** is formed on an inner side wall of the second through-hole **110HB**), and a semiconductor chip **120** is disposed on the second adhesive film **215** in the second through-hole **110HB**. Then, the second encapsulant **132** is used to seal the semiconductor chip **120** in the second through-hole **110HB**.

Referring to FIG. **11C**, first, a carrier **220**, including a core layer **222** and upper and lower first conductive layers **224**, disposed on both sides of the core layer **222**, is prepared, the carrier **220** is attached to the second encapsulant **132**, the second adhesive film **215** is removed from a lower surface, and second and third insulating layers **141b** and **141c**, second and third redistribution layers **142b** and **142c**, and second and third vias **143b** and **143c** are formed to form a connection structure **140**. Moreover, a first passivation layer **150**, covering the connection structure **140**, is formed, an opening exposing at least a portion of the third redistribution layer **142c** is formed in the first passivation layer **150**, and an underbump metal layer **160** is formed in the opening. The carrier **220** may be, for example, a double cladding fiber (DCF), and may control warpage, during formation of the connection structure **140**. According to embodiments, before the carrier **220** is attached, a surface treatment process is performed on an upper surface of the second encapsulant **132** to increase surface roughness. Next, the core layer **222** and the upper first conductive layer **224** are detached, so that only the lower first conductive layer **224** remains of the carrier **220**. Accordingly, only the lower first conductive layer **224** remains in the upper surface of the second encapsulant **132**.

Referring to FIG. **11D**, after a via hole passing through the lower first conductive layer **224** is formed, a mask pattern **230** is formed, and the lower first conductive layer **224** is used as a plating seed layer to perform a plating process, so a second conductive layer **182aE** and a first backside via **183a** are formed. Accordingly, a side surface of the first backside via **183a** is extended upwardly to pass through the lower first conductive layer **224**, and the first backside via **183a** may have a form connected to (or integrated with) the second conductive layer **182aE**. Then, the mask pattern **230** and portions of the lower first conductive layer **224** below the mask pattern **230** are removed. Thus, a first metal layer **182a** including a second conductive layer **182aE** and a first

conductive layer **182aS** formed of the lower first conductive layer **224** of the carrier **200**, may be formed.

Referring to FIG. **11E**, on the first metal layer **182a**, a backside insulating layer **181**, a second metal layer **182b**, and a second backside via **183b** are formed to form a backside connection structure **180**, and a second passivation layer **190** is formed. According to embodiments, the first passivation layer **150** and the underbump metal layer **160** may be formed in this operation. In this case, the first passivation layer **150** may be formed simultaneously with the second passivation layer **190**, or may be formed using a separate process. Then, an electrical connection metal **170** is formed on the underbump metal layer **160**. In some cases, only the underbump metal layer **160** may be formed, and thereafter, a customer company may optionally form an electrical connection metal by a separate subsequent process.

Meanwhile, a series of processes may include manufacturing a large-sized frame **110** to facilitate mass production, manufacturing a plurality of packages **100A** by the above-mentioned processes, and then performing a process of singulation for individual packages **100A** by a sawing process.

FIG. **12** is a schematic cross-sectional view illustrating another example of a semiconductor package.

Referring to FIG. **12**, a semiconductor package **100B** according to another embodiment may include a frame **110** having first through-holes **110HA1** and **110HA2** and a second through-hole **110HB**, at least one passive component **125a** and at least one passive component **125b** disposed in the first through-holes **110HA1** and **110HA2** of the frame **110**, a semiconductor chip **120** disposed in the second through-hole **110HB** of the frame **110**, and having an active surface on which the connection pad **122** is disposed and an inactive surface opposing the active surface, a first encapsulant **131** sealing at least portions of the frame **110** and the passive components **125a** and **125b**, a second encapsulant **132** sealing at least portions of the frame **110** and the semiconductor chip **120**, a connection structure **140** disposed on the frame **110**, lower surfaces of the passive components **125a** and **125b**, and the active surface of the semiconductor chip **120**, a metal layer **185** disposed on the second encapsulant **132** and including a first conductive layer **185S** and a second conductive layer **185E**, a backside via **184** connecting the metal layer **185** to the frame **110**, a passivation layer **150** disposed on the connection structure **140**, an underbump metal layer **160** disposed in an opening of the passivation layer **150**, and an electrical connection metal **170** disposed on the passivation layer **150** and connected to the underbump metal layer **160**.

The metal layer **185** is disposed to cover the semiconductor chip **120** and the passive component **125** on the second encapsulant **132**, and may be connected to the frame metal layer **115** of the frame **110** through a backside via **184** passing through the first and second encapsulants **131** and **132**. At least a portion of the metal layer **185** may be disposed to overlap the semiconductor chip **120** in an upper portion of the semiconductor chip **120**. The backside via **184** may have a form of passing through a portion of the metal layer **185**, for example, a first conductive layer **185S**, to be connected to the second conductive layer **185E**. The backside via **184** and the metal layer **185** are disposed to surround the semiconductor chip **120** and the passive component **125** (e.g., with the frame metal layer **115** they are electrically connected to), thereby further improving an EMI shielding effect and heat dissipation effect of a package. The backside via **184** and the metal layer **185** may include a conductive

material such as copper (Cu), aluminum (Al), silver (Ag), tin (Sn), gold (Au), nickel (Ni), lead (Pb), titanium (Ti), or alloys thereof. The backside via **184** and the metal layer **185** may be used as a ground line. In this case, the backside via **184** and the metal layer **185** may be electrically connected to a ground among the redistribution layers **142a**, **142b**, and **143c** of the connection structure **140** via the frame metal layer **115**. The metal layer **185** may have a plate form covering most of an upper surface of the second encapsulant **132**. The backside via **184** may have a form of a trench via or a line via having a predetermined length. In this case, substantially all of movement paths of the electromagnetic waves are blocked, and thus the effect of shielding electromagnetic waves may be further excellent. However, it is not limited thereto. Here, in a range in which an effect of shielding electromagnetic waves is provided, the metal layer **185** may have a form including a plurality of plates, and openings may be formed in the regions between the backside vias **184** to provide a gas movement path.

The metal layer **185** is disposed to be in contact with an upper surface of the second encapsulant **132**, and may include a first conductive layer **185S** and a second conductive layer **185E**, vertically stacked, in a manner similar to the first metal layer **182a** in the package **100A** of an embodiment of FIG. **9**. A lower surface of the first conductive layer **185S** is in direct contact with an upper surface of the second encapsulant **132**, and may have roughness along an upper surface of the second encapsulant **132**, that is, surface roughness. The upper surface of the second encapsulant **132** may have roughness formed intentionally for improving roughness or a bonding force according to characteristics of a material of the second encapsulant **132**. Thus, a lower surface of the first conductive layer **185S** may have first surface roughness. An upper surface of the first conductive layer **185S** is in direct contact with the second conductive layer **185E**, and may have second surface roughness, smaller than the first surface roughness. The second surface roughness may have a small value, close to zero.

The first conductive layer **185S** may be, for example, a copper foil layer including a copper (Cu) foil, and the second conductive layer **185E** may be an electroplated layer formed using the first conductive layer **185S** as a seed layer. For example, the second conductive layer **185E** may be a layer including copper (Cu) in a manner similar to the first conductive layer **185S**. A thickness of the second conductive layer **185E** may be greater than a thickness of the first conductive layer **185S**, but is not limited thereto. The first conductive layer **185S** may be a copper foil, forming a portion of a carrier, during a manufacturing process of the semiconductor package **100A**. As the first conductive layer **185S**, the copper foil, is disposed on the second encapsulant **132**, adhesion may be improved, as compared with the case in which chemical copper is disposed on the second encapsulant **132** by electroless plating. Moreover, since a portion of the carrier, used during a manufacturing process, is used as a seed layer for plating, a manufacturing process may be simplified.

Other configurations are substantially the same as those described in the above-described semiconductor package **100A** and the like, and a detailed description thereof will be omitted.

FIG. **13** is a schematic cross-sectional view illustrating another example of a semiconductor package.

Referring to FIG. **13**, in a semiconductor package **100C** according to another example, a frame **110** may include a first frame insulating layer **111a** in contact with a connection structure **140**, a first wiring layer **112a** in contact with the

connection structure **140** and embedded in the first frame insulating layer **111a**, a second wiring layer **112b** disposed on a side opposing the side in which the first wiring layer **112a** of the first frame insulating layer **111a** is embedded, a second frame insulating layer **111b** disposed on the first frame insulating layer **111a** and covering the second wiring layer **112b**, and a third wiring layer **112c** disposed on the second frame insulating layer **111b**. The first to third wiring layers **112a**, **112b**, and **112c** are electrically connected to the connection pad **122**. The first wiring layer **112a** and the second wiring layer **112b**, as well as the second wiring layer **112b** and the third wiring layer **112c** may be electrically connected to each other through the first frame via **113a** and the second frame via **113b**, passing through the first frame insulating layer **111a** and the second frame insulating layer **111b**, respectively.

The first wiring layer **112a** may be recessed inwardly of the first frame insulating layer **111a**. As described above, when the first wiring layer **112a** is recessed inwardly of the first frame insulating layer **111a** and a step is provided between a lower surface of the first frame insulating layer **111a** and a lower surface of the first wiring layer **112a**, the first wiring layer **112a** may be prevented from being contaminated by bleeding of a formation material of the first encapsulant **130**. A thickness of each of the wiring layers **112a**, **112b**, and **112c** of the frame **110** may be greater than that of each of the redistribution layers **142a**, **142b**, and **142c** of the connection structure **140**.

When a hole for the first frame via **113a** is formed, some pads of the first wiring layer **112a** may serve as a stopper. In this regard, it may be advantageous in a process in that the first frame via **113a** has a tapered shape in which a width of an upper surface is greater than a width of a lower surface contacting the first wiring layer **112a** serving as the stopper. In this case, the first frame via **113a** may be integrated with a pad pattern of the second wiring layer **112b**. When a hole for the second frame via **113b** is formed, some pads of the second wiring layer **112b** may serve as a stopper. In this regard, it may be advantageous in a process in that the second frame via **113b** has a tapered shape in which a width of an upper surface is greater than a width of a lower surface. In this case, the second frame via **113b** may be integrated with a pad pattern of the third wiring layer **112c**.

Other configurations are substantially the same as those described in the above-described semiconductor package **100A** and the like, and a detailed description thereof will be omitted.

FIG. **14** is a schematic cross-sectional view illustrating another example of a semiconductor package.

Referring to FIG. **14**, in a semiconductor package **100D** according to another example, a frame **110** may include a first frame insulating layer **111a**, a first wiring layer **112a** and a second wiring layer **112b** disposed on opposite sides/surfaces of the first frame insulating layer **111a**, respectively, a second frame insulating layer **111b** disposed on the first frame insulating layer **111a** and covering the first wiring layer **112a**, a third redistribution layer **112c** disposed on the second frame insulating layer **111b**, a third frame insulating layer **111c** disposed on the first frame insulating layer **111a** and covering the second wiring layer **112b**, and a fourth wiring layer **112d** disposed on the third frame insulating layer **111c**. The first to fourth wiring layers **112a**, **112b**, **112c**, and **112d** may be electrically connected to connection pads **122**. Since the frame **110** may include a further large number of wiring layers **112a**, **112b**, **112c**, and **112d**, a connection structure **140** may be further simplified. Therefore, a decrease in a yield depending on a defect occurring in a

process of forming the connection structure **140** may be suppressed. Meanwhile, the first to fourth wiring layers **112a**, **112b**, **112c**, and **112d** may be electrically connected to each other through first to third frame vias **113a**, **113b**, and **113c** passing through the first to third frame insulating layers **111a**, **111b**, and **111c**, respectively.

The first frame insulating layer **111a** may have a thickness greater than those of the second frame insulating layer **111b** and the third frame insulating layer **111c**. The first frame insulating layer **111a** may be basically relatively thick in order to maintain rigidity, and the second frame insulating layer **111b** and the third frame insulating layer **111c** may be introduced in order to form a larger number of wiring layers **112c** and **112d**. The first frame insulating layer **111a** may include an insulating material different from those of the second frame insulating layer **111b** and the third frame insulating layer **111c**. For example, the first frame insulating layer **111a** may be, for example, prepreg including a core material, a filler, and an insulating resin, and the second insulating layer **111b** and the third insulating layer **111c** may be an ABF film or a PID film including a filler and an insulating resin. However, the materials of the first frame insulating layer **111a** and the second and third frame insulating layers **111b** and **111c** are not limited thereto. Similarly, the first frame via **113a** passing through the first frame insulating layer **111a** may have a diameter greater than those of the second and third frame vias **113b** and **113c** passing through the second and third frame insulating layers **111b** and **111c**, respectively. A thickness of each of the wiring layers **112a**, **112b**, **112c**, and **112d** of the frame **110** may be greater than that of each of the redistribution layers **142a**, **142b**, and **142c** of the connection structure **140**.

Other configurations are substantially the same as those described in the above-described semiconductor package **100A** and the like, and a detailed description thereof will be omitted.

FIG. **15** is a schematic plan view illustrating an effect in a case in which the semiconductor package according to the disclosure is applied to an electronic device.

Referring to FIG. **15**, recently, as a size of display for mobile devices **1100A** and **1100B** increases, the desirability of increasing battery capacity is increasing. As the battery capacity increases, an area occupied by the battery **1180** increases. In this regard, a size of a printed circuit board **1101** such as a mainboard is advantageously reduced. Thus, due to a reduction in amounting area of a component, an area occupied by a module **1150** including a power management integrated circuit (PMIC) and passive components is gradually decreased. In this case, when the semiconductor package of any of packages **100A**, **100B**, **100C**, and **100D** according to an embodiment is applied to the module **1150**, a size is able to be reduced. Thus, the area, which becomes smaller as described, above may be effectively used.

As set forth above, according to an embodiment in the present disclosure, adhesion between a metal layer and an encapsulant is improved in an upper portion of a semiconductor chip, and a semiconductor package to be manufactured in a simplified process may be provided.

While exemplary embodiments have been shown and described above, it will be apparent to those skilled in the art that modifications and variations could be made without departing from the scope of the present invention as defined by the appended claims.

What is claimed is:

1. A semiconductor package comprising:
 - a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface;
 - an encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip;
 - a metal layer disposed on the encapsulant, and including a first conductive layer and a second conductive layer, sequentially stacked in direct contact with each other; and
 - a connection structure disposed on the active surface of the semiconductor chip, and including a first redistribution layer electrically connected to the connection pad,
 wherein each of the first and second conductive layers extends to overlap, in a stacking direction of the semiconductor chip on the connection structure, with an entire upper surface of the semiconductor chip.
2. The semiconductor package of claim 1, wherein a lower surface of the first conductive layer is in contact with the encapsulant and has first surface roughness, and an upper surface of the first conductive layer is in contact with the second conductive layer and has second surface roughness smaller than the first surface roughness.
3. The semiconductor package of claim 1, wherein the first and second conductive layers are each electrically connected to a frame metal layer extending around an entire periphery of the semiconductor chip between the metal layer and the connection structure.
4. The semiconductor package of claim 3, wherein the first and second conductive layers are each electrically connected to the frame metal layer by a plurality of backside vias extending through the encapsulant and the first conductive layer to directly contact both the second conductive layer and the frame metal layer.
5. A semiconductor package, comprising:
 - a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface;
 - a first encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip;
 - a metal layer disposed on the first encapsulant, and including a first conductive layer and a second conductive layer, sequentially stacked; and
 - a connection structure disposed on the active surface of the semiconductor chip, and including a first redistribution layer electrically connected to the connection pad,
 wherein a lower surface of the first conductive layer is in contact with the first encapsulant and has first surface roughness, and an upper surface of the first conductive layer is in contact with the second conductive layer and has second surface roughness smaller than the first surface roughness.
6. The semiconductor package of claim 1, wherein at least a portion of the metal layer is disposed to overlap the semiconductor chip in a stacking direction of the semiconductor chip on the connection structure.
7. The semiconductor package of claim 1, wherein the second conductive layer is an electroplated layer formed using the first conductive layer as a seed layer.
8. The semiconductor package of claim 1, wherein the metal layer is electrically connected to the semiconductor chip to form a second redistribution layer.

9. The semiconductor package of claim 1, wherein the first conductive layer and the second conductive layer are formed of a same metal material.
10. The semiconductor package of claim 1, wherein the metal layer extends over an entirety of an upper surface of the first encapsulant.
11. The semiconductor package of claim 1, wherein a lower surface of the second conductive layer has the second surface roughness.
12. The semiconductor package of claim 1, wherein an upper surface of the first encapsulant has the first surface roughness.
13. The semiconductor package of claim 1, further comprising:
 - a frame disposed on the connection structure, and having a first through-hole in which the semiconductor chip is disposed.
14. The semiconductor package of claim 13, wherein the frame further has a second through-hole, and the semiconductor package further comprises one or more passive components disposed in the second through-hole.
15. The semiconductor package of claim 14, further comprising:
 - a second encapsulant covering at least a portion of each of an upper surface and a side surface of the one or more passive components, and
 - wherein the first encapsulant covers an upper surface of the second encapsulant.
16. The semiconductor package of claim 13, further comprising:
 - a via passing through the first encapsulant to connect the metal layer to the frame.
17. The semiconductor package of claim 16, wherein the via extends through the first conductive layer to contact the second conductive layer.
18. A semiconductor package, comprising:
 - a semiconductor chip having an active surface on which a connection pad is disposed and an inactive surface opposing the active surface;
 - an encapsulant covering at least a portion of each of the inactive surface and a side surface of the semiconductor chip;
 - a metal layer disposed on the encapsulant, having at least a portion extended to overlap an upper portion of the semiconductor chip, and having a first conductive layer and a second conductive layer that are sequentially stacked;
 - a via passing through a portion of the encapsulant and connected to the metal layer; and
 - a connection structure disposed on the active surface of the semiconductor chip, and including a redistribution layer electrically connected to the connection pad,
 wherein a lower surface of the first conductive layer is in contact with the encapsulant and has roughness along a surface of the encapsulant, and an upper surface of the first conductive layer is in contact with the second conductive layer and is flat.
19. The semiconductor package of claim 18, wherein surface roughness of an upper surface of the second conductive layer is substantially equal to surface roughness of the upper surface of the first conductive layer.
20. The semiconductor package of claim 18, further comprising:
 - a passivation layer covering the metal layer.